

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number	: 31082		
Estimate Number	: 12775		
P.O. Number	: N/A	Part Number	: D350600241
This Issue	: 3/7/2007      S.O. No. : N/A	Drawing Number	: D3188,ICA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007      Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31081	Material	: N/A
Written By	:	Due Date	: 3/30/2007      Qty:      1   Um:      Each
Checked & Approved By	:		
Comment	: Est Rev A   07.03.07   new issue   ec		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

2.0	31082A	SWITCH RELOCATION KIT
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**Comment:** Sub-Component SWITCH RELOCATION KIT

3.0	31082B	SPACEPOD BODY LH
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**Comment:** Sub-Component SPACEPOD BODY LH

D3188-1M Batch: \_\_\_\_\_

4.0 31082C SPACEPOD DOOR LH

**Comment:** Sub-Component SPACEPOD DOOR LH

5.0 D31871 Spacepod Floor

**Comment:** Qty.: 1.0000 Each(s)/Unit      Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch	
1	D3187-1	Floor	<u>B25404</u>	x(
1	D3186-3	Door (ref)	<u>N/A</u>	
1	D3188-1	Body(ref)	<u>N/A</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/7/2007 4:31:42 PM  
User: Kim Johnston

## Process Sheet

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31082

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

~~ALISA~~ -1030-130 Insert



60 QSI 017



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch:

M102776

m 07/04/10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

m 07/04/10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/11

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

\*\*\*\*\*D3187-1 floor only\*\*\*\*\*

Chemical Conversion Coat as per QSI 005 4.1

m-l 07/04/12

10.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

\*\*\*\*\*D3187-1 floor only\*\*\*\*\*

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-l 07/04/12

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 07/04/12

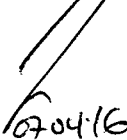


6B

Washer A ou

AN 3235-020-935 X 8 M103962

PTO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/04/10	6B	Permanent change : add in listing parts these washers A 3235-020-935 X8	ml			 07/04/16	 07/04/16	
		<del>do not need QES inspection at this step</del> <del>take out</del> <del>Permanent change</del>						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31082

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



N/A

PTO

Comment: INSPECT WORK TO CURRENT STEP

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)  
neoprene foam  
batch: B24628

ml 07/03/28

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/03/28

55 lb

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch: M102565

ml 07/04/13

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/16

16.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Label  
batch: B31116 -

PTO

17.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lock Nut  
batch: B30169 -

18.0

D35471

BRACKET


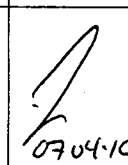
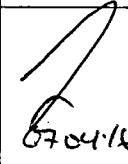
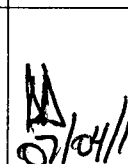


Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BRACKET  
batch: B30636 -

SP 04/03/290

PTO

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/04/10	12 <del>12</del> <del>12</del>	do not need QC5 inspection at this step take out  Permanent change.	ml			 07-04-10	 07-04-10	
07/04/10	16 and 18	this label (D2985) should go in picking list <hr/> D3547-1 Bracket too Permanent change.	ml			 07-04-10	 07/04/10	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: B31148-

20.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210-

21.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B31127-

22.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: D30680-

23.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: M4067-

24.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B31123-

25.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B21490-

*Handwritten signature/initials*

*PTO*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/04/10	19	this Strut (D3550-1) should go in picking list.  Permanent change						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31082

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw  
batch: M103574-

27.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
batch: M103492-

28.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
batch: M103538-

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600  
\*\*\*Hardware on previous steps is for body & floor\*\*\*\*

N/A m107/04/05

30.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
CARBON STEEL GAS SPRING  
batch: B30638-

P70

31.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: M103585-

32.0

AN960JD8


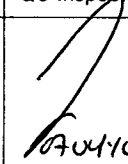
Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
batch: M103492-

CP 04/03/29 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
04/04/10	30	the gas spring (D3552-7) should go in picking test  Permanent change.	ml			 07-04-10	 07-04-10

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31082

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100993-

34.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M103538-

35.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681-

36.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B31127-

37.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: D29071-

38.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: B30814-

39.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B29995-

*Handwritten signature/initials*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31082

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: 115057 -

41.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer  
batch: 1103641 -

42.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Nut  
batch: 1102658 -

43.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Hinge Bracket  
batch: B30885 -

44.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Hinge Bracket  
batch: B29022 -

45.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Backing Plate  
batch: M 30679

ml 07/04/10

46.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Screw  
batch: 1103585 -

JP 04/03/290

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/7/2007 4:31:43 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31082

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M103492 -

48.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M103538 -

49.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B30644 -

50.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210 -

51.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty 2

Washer

batch: M102519 -

52.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B30169 -

53.0

AN526C832R14

Screw

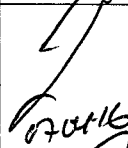
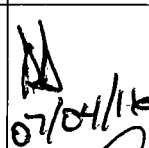

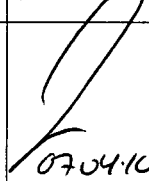




Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M9216 -

*Boz/03/290*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/04/10	51	Permanent change Quantity should need 2 washers AN 960 JDS16 at this step.	ml			 07/04/10	 07/04/10	
	50	this ball stud (D3554-7) should go in picking list	ml			 07/04/10	 07/04/10	
	52	lock Nut D.3015-3 Too Permanent change.				 07/04/10	 07/04/10	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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54.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 1103585

*07/03/29*

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

55p



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

*07/04/16 P10*

56.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/04/16*

57.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

54.1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: 1103707

*FR*

*07/04/12*

58.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

54.2



Comment: Inspect Wing Walk

*07/04/12*

59.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

*B 31130*

*07/04/16*

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*07/04/16*

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev: *A*

*07/04/16*

*1*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/04/12	55	Should add on this step (as 11ND350-600) Hypol 934 m 103922 exp: March 2008 milled fiber 10% M100859 Permanent	ml			04-07-16	07/04/16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/16  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

62.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Post 104/16*

Job Completion



*U Start 1/6*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

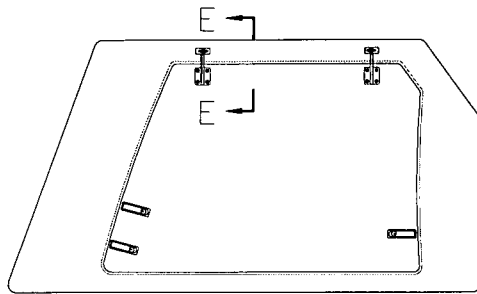


FIGURE 3. LOOKING AT OUTSIDE OF  
D350-600-145 DOOR  
(D350-600-146 SIMILAR AND OPPOSITE)

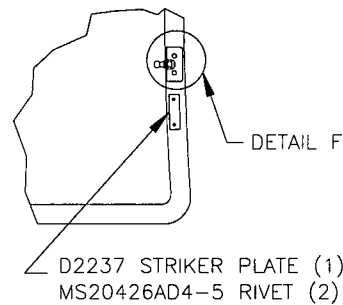


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

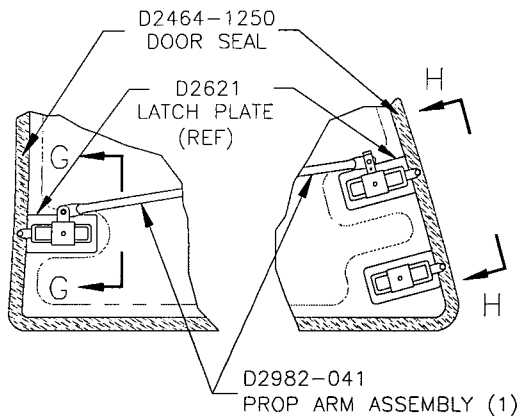
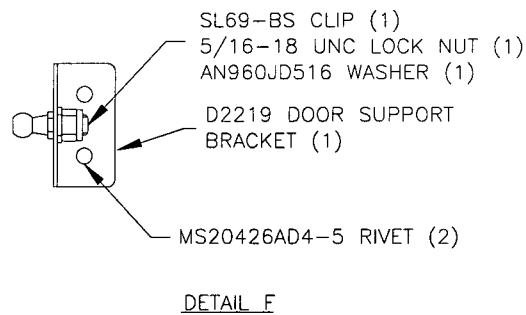


FIGURE 5. LOOKING AT TYPICAL INSIDE  
OF D350-600-145/-146 DOOR



TC Accepted

MAY 07 2003

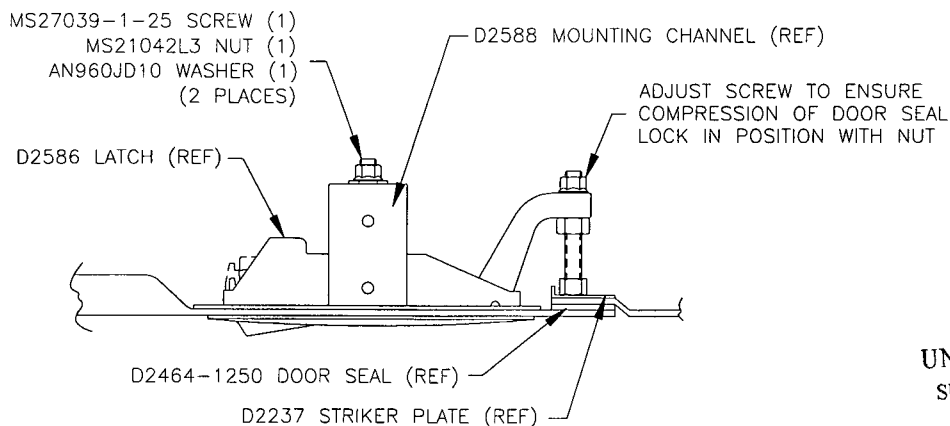
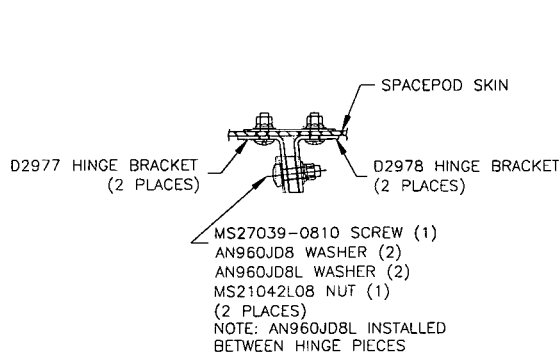


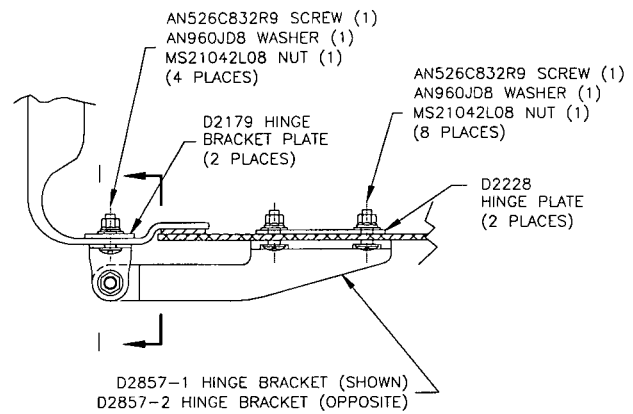
FIGURE 6. TYPICAL LATCH INSTALLATION

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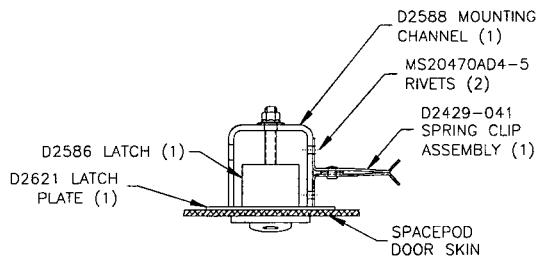
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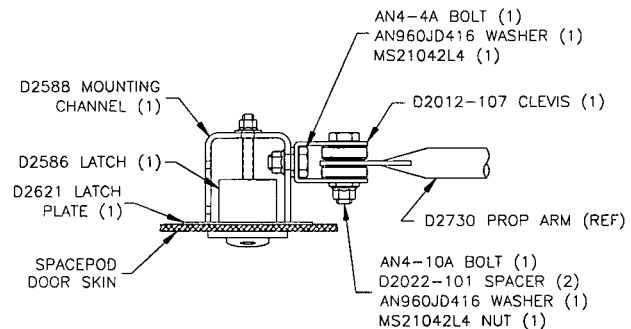
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



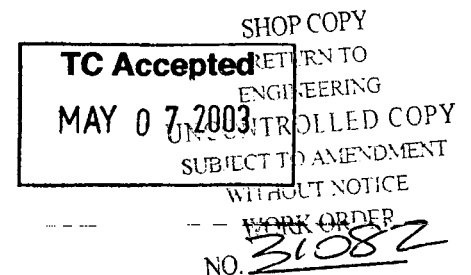
SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

### 25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



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25-00-00

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07.02.22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CE	DRAWING NO.	REV. D
CHECKED	APPROVED	D3188	SHEET 1 OF 11
DATE		TITLE	SCALE
07.02.22		SPACEPOD BODY	NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

## GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART  
D3188-1M/-1/-5  
D3188-2M/-2/-6  
D3188-3M/-3/-7

LAYUP  
DT8003  
DT8004  
DT8500

TRIM AND DRILL  
DT8501  
DT8502  
DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

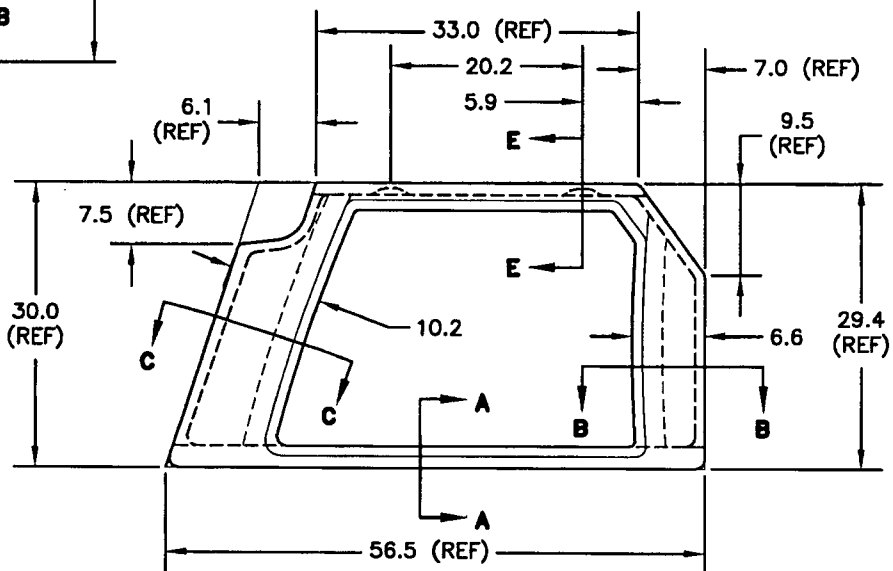
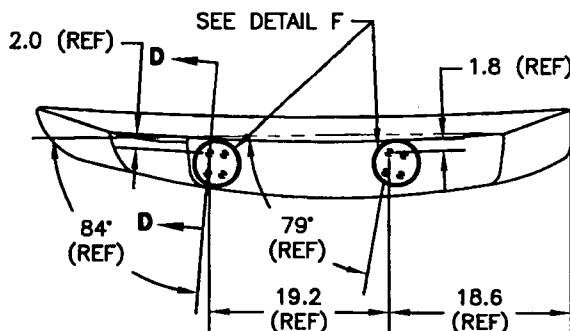
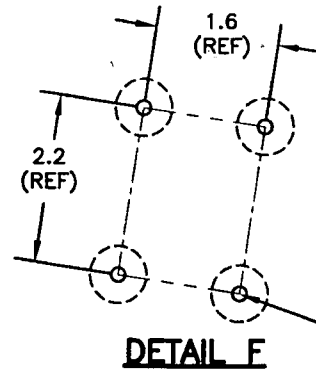
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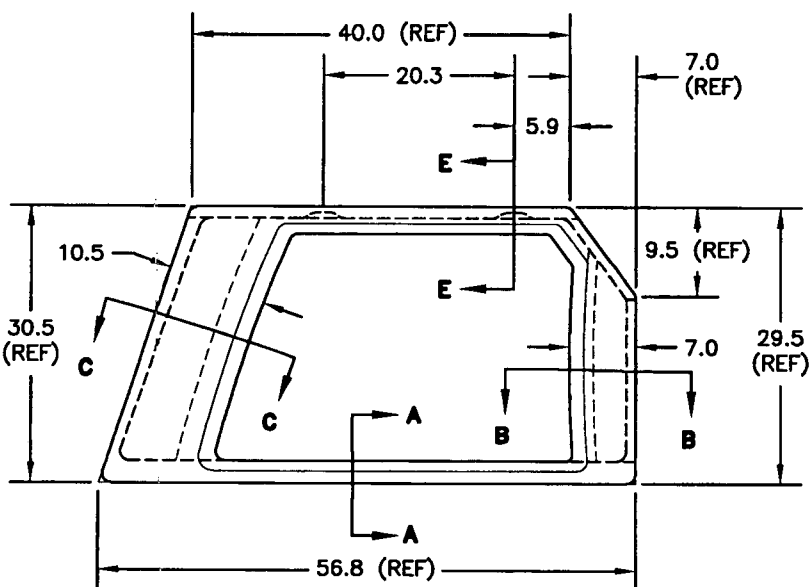
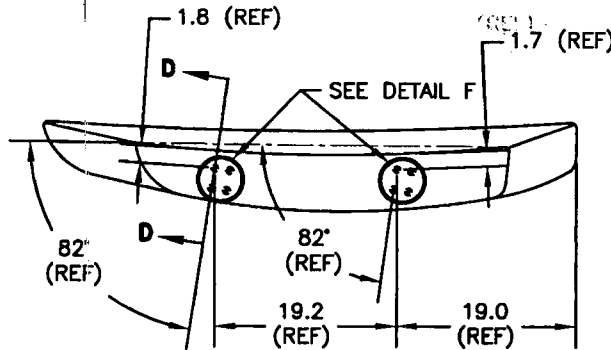
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**D3188-3M SPACEPOD BODY**



**D3188-1M SPACEPOD BODY**

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		SCALE	NTS		

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**D3186-1M/-3M NOTES:**

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2. SEE SHEET #4 FOR SECTION VIEWS.

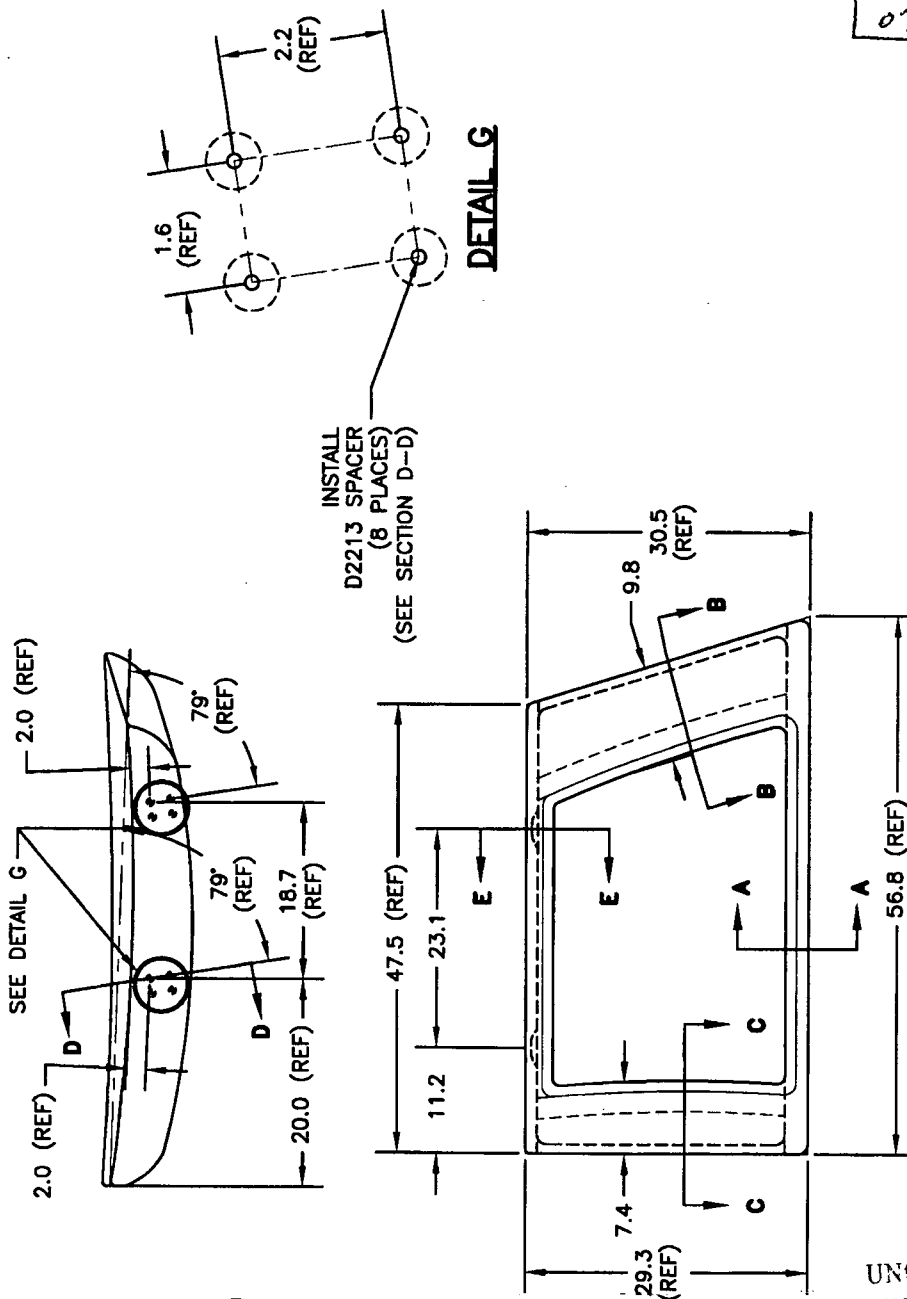


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D3186-2M NOTES:  
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2. SEE SHEET #4 FOR SECTION VIEWS.

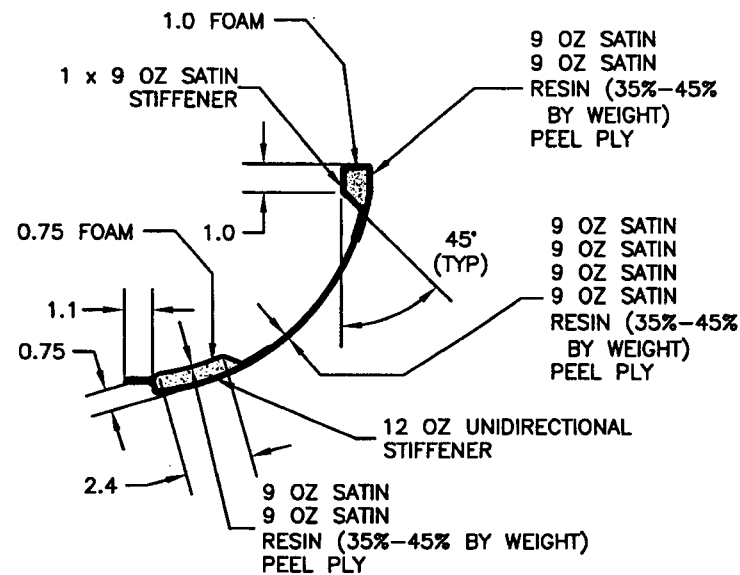
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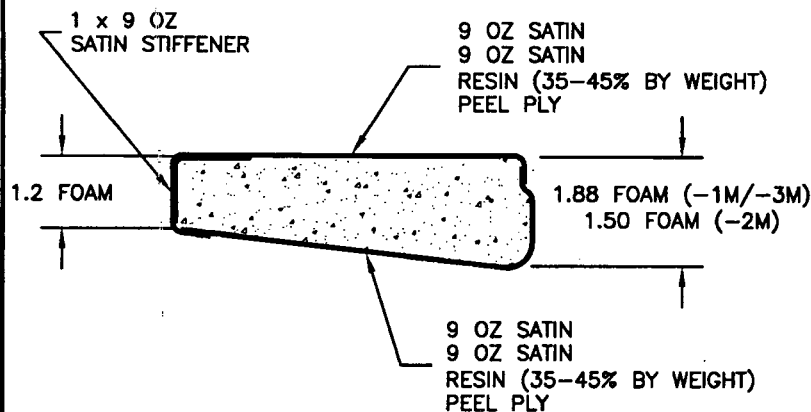
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		SCALE	NTS		

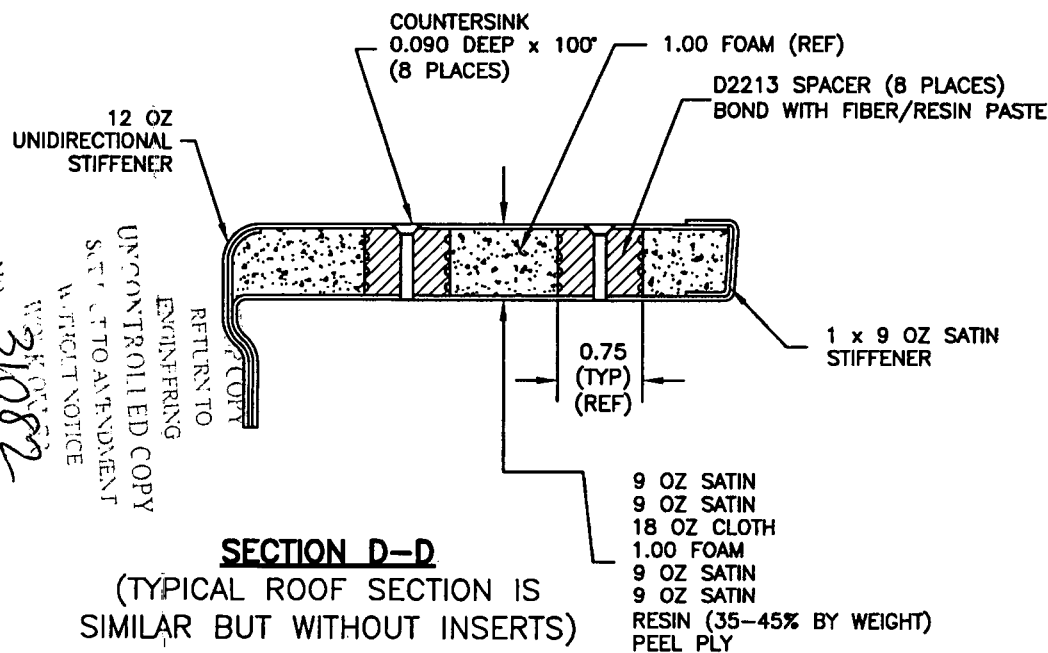
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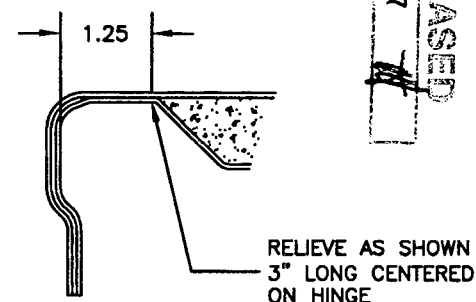
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

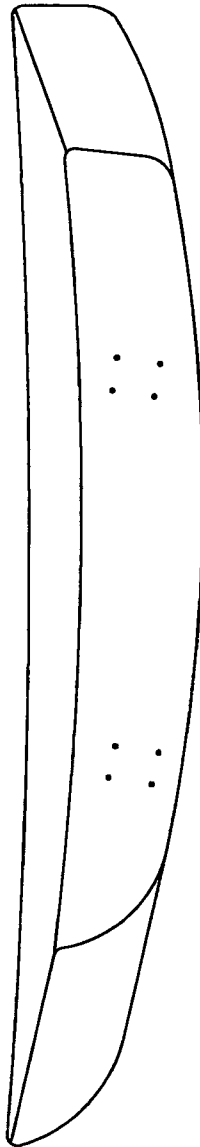
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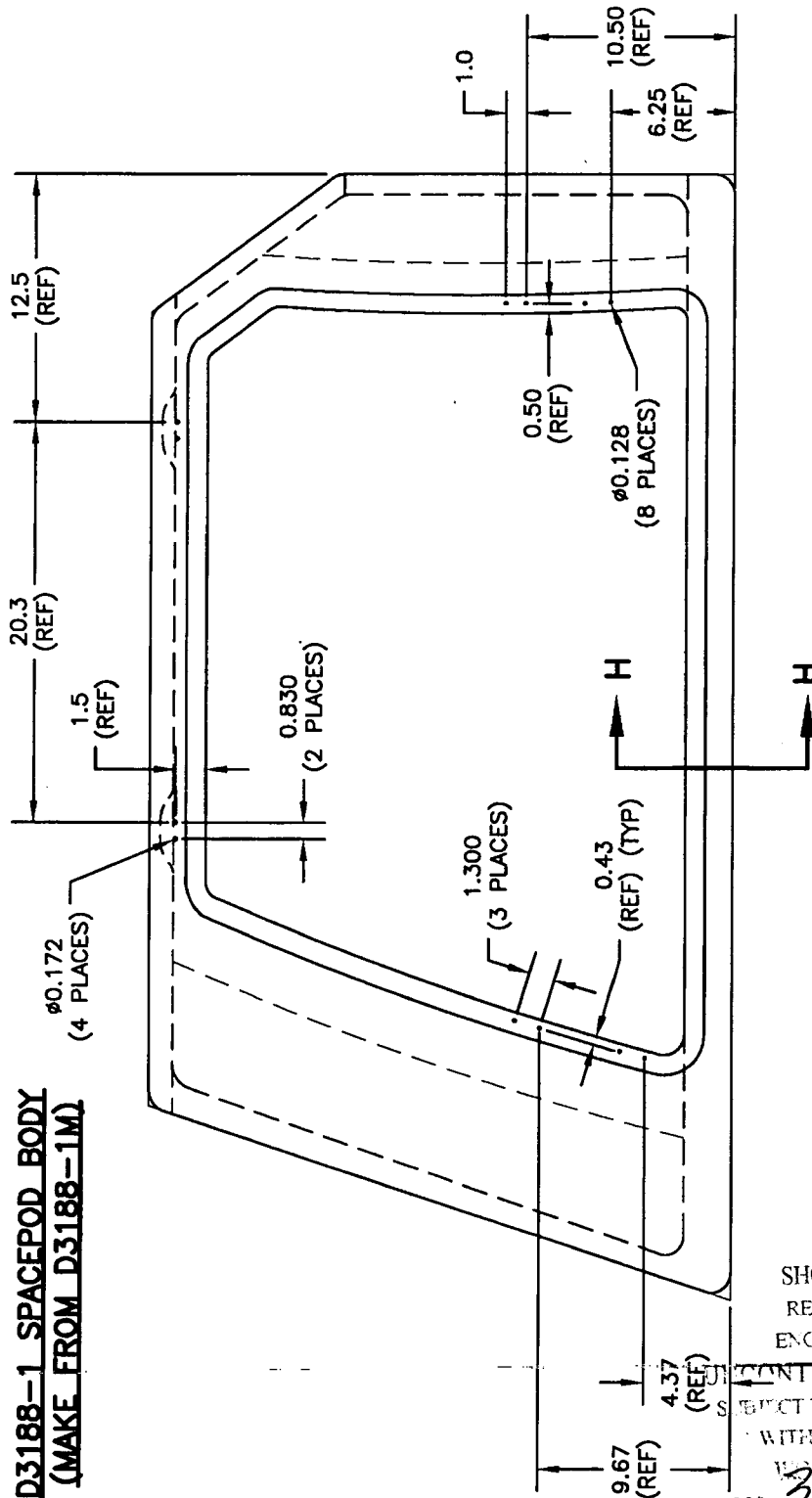
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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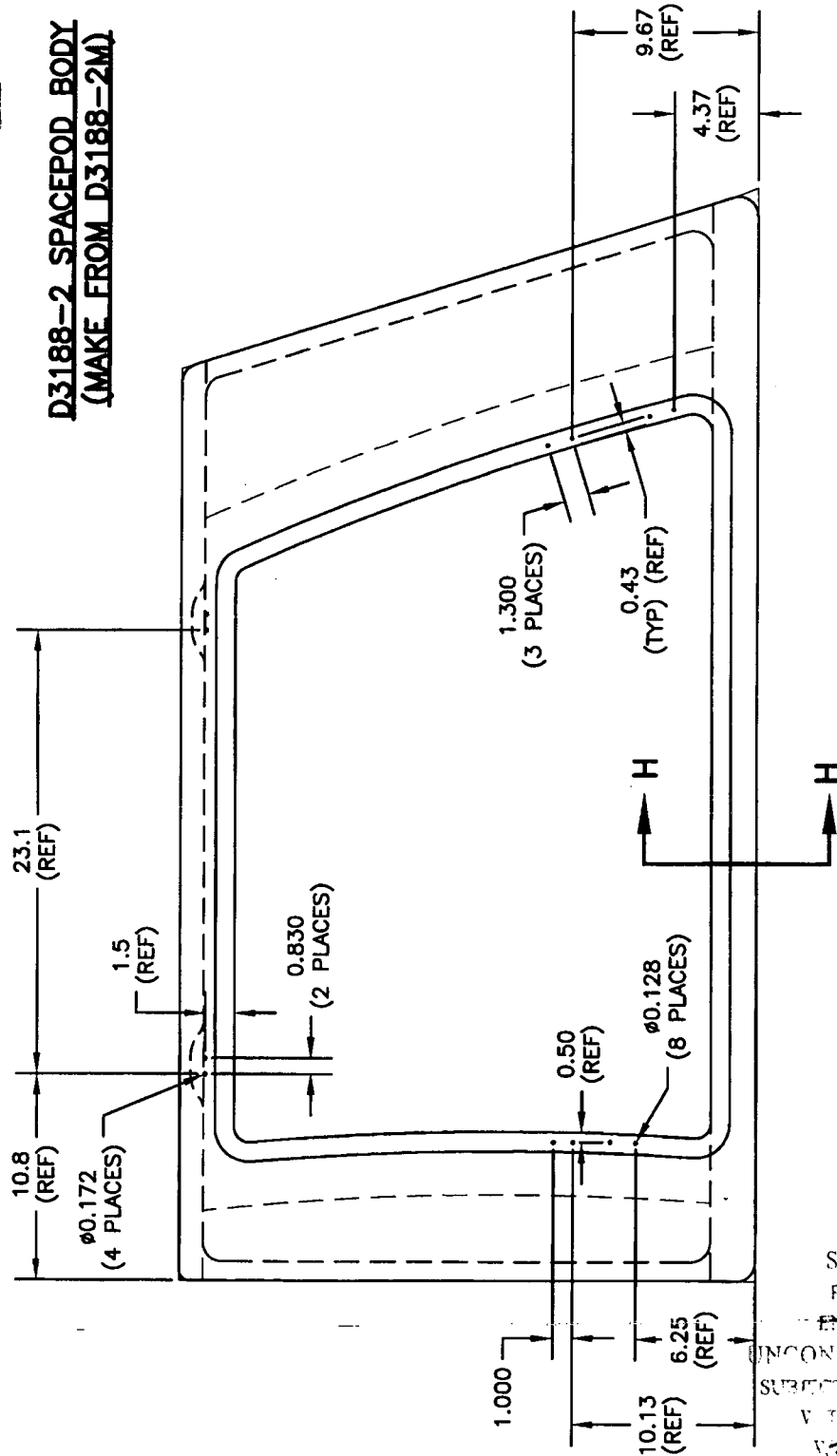
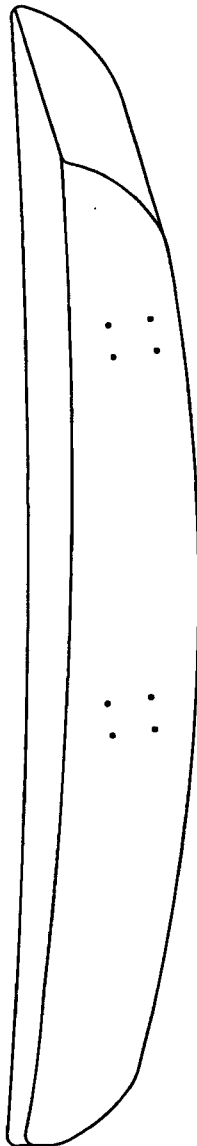
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**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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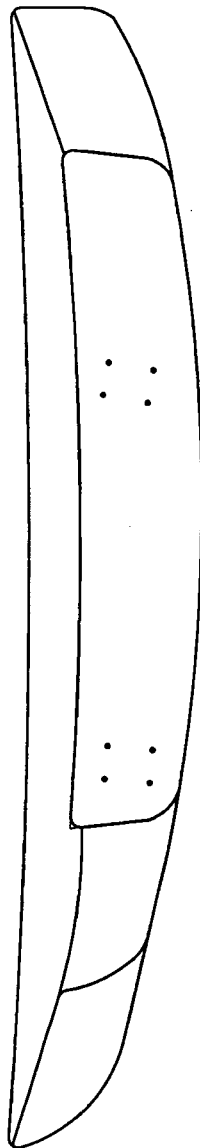
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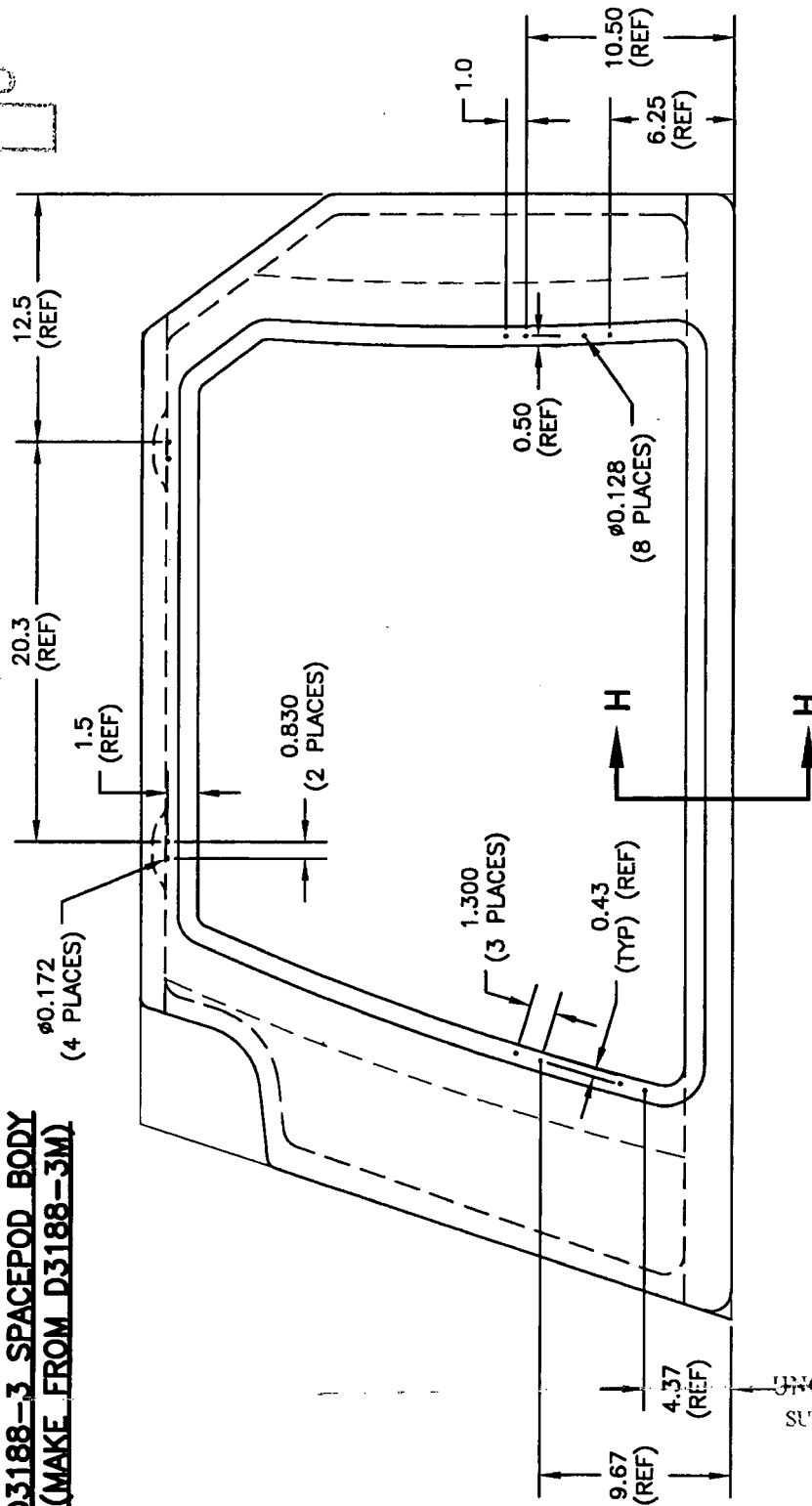
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-3 SPACEPOD BODY**  
**(MAKE FROM D3188-3M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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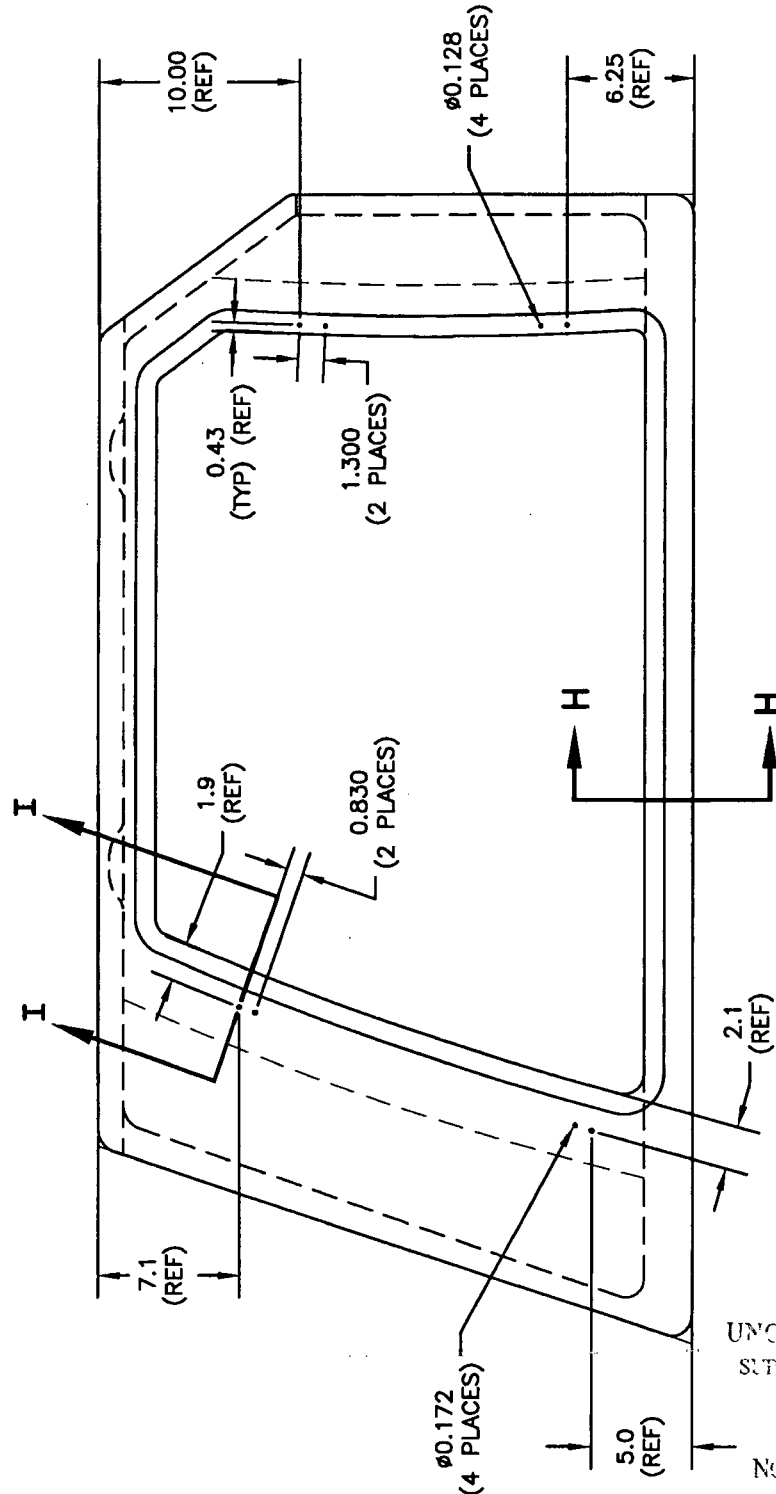
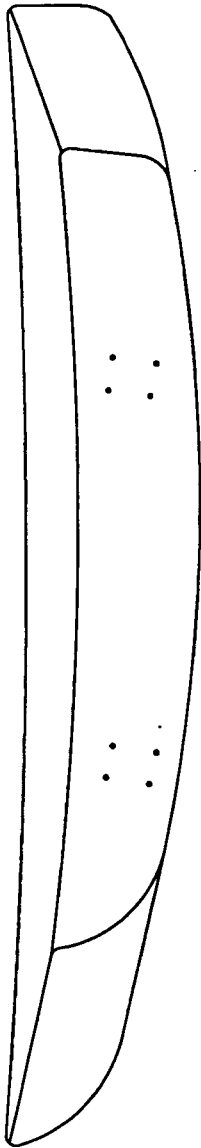


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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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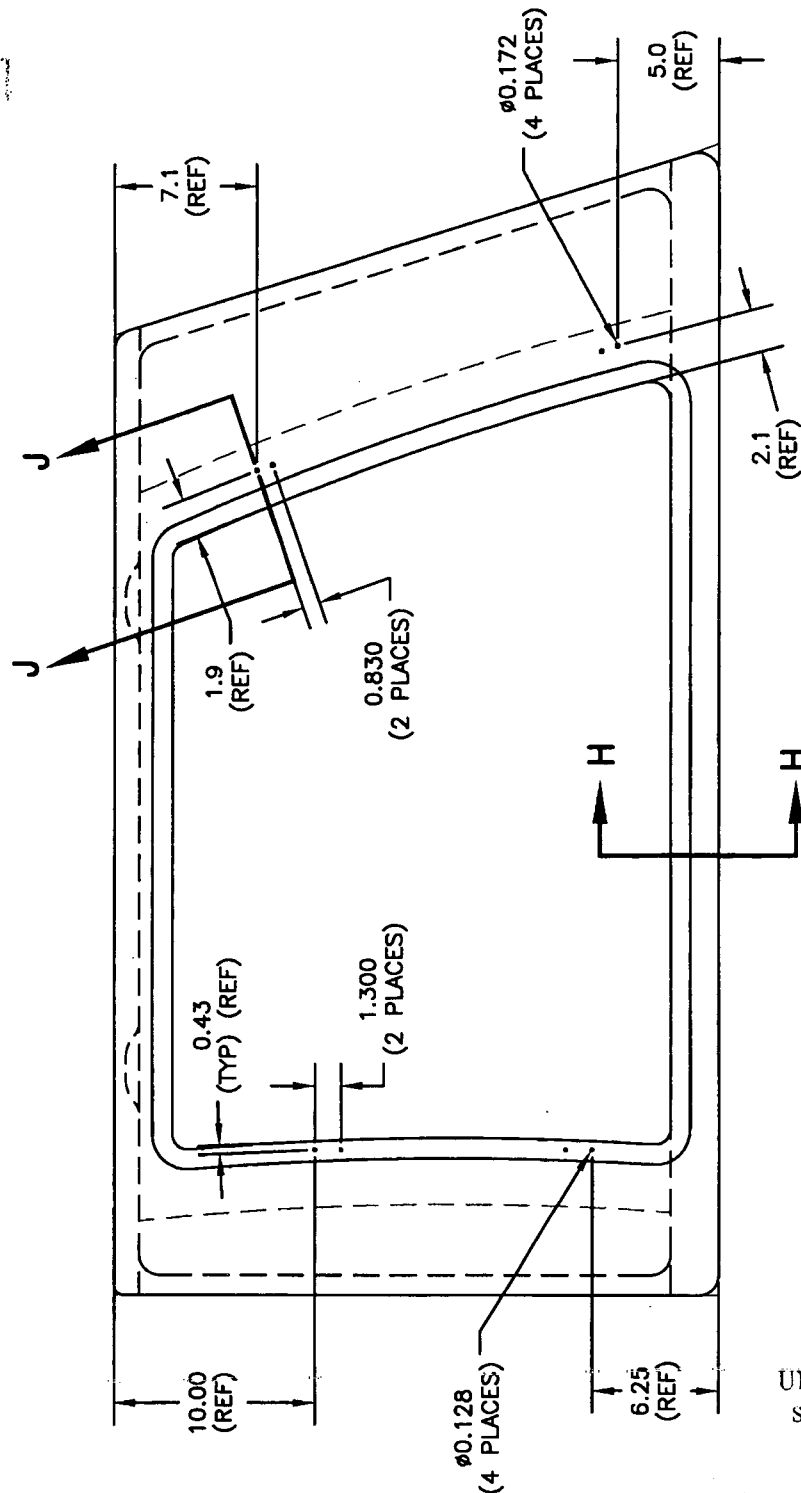
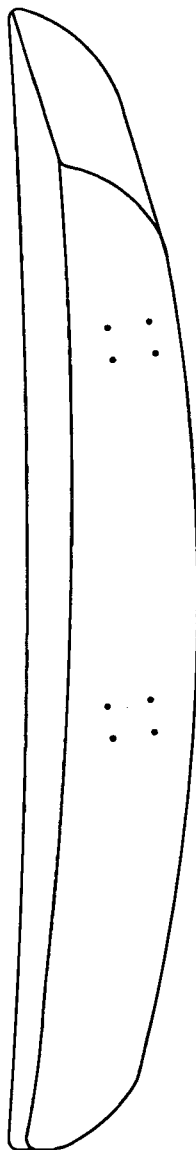
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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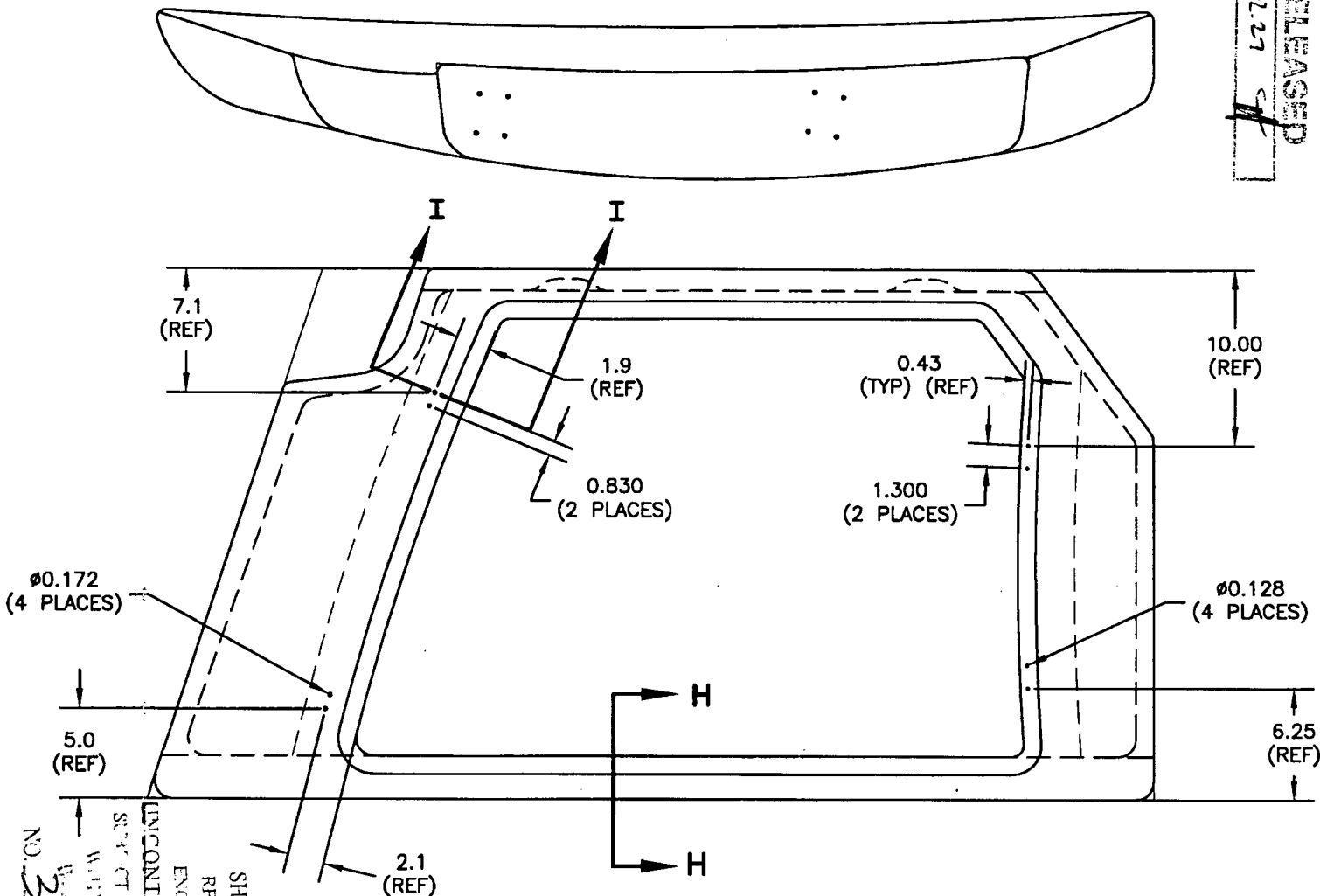
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		DRAWING NO.	D3188
		SHEET 10 OF 11	
		SCALE	NTS

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07.02.22

**D3188-7 SPACEPOD BODY**  
**(MAKE FROM D3188-3M)**



**NOTE:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS



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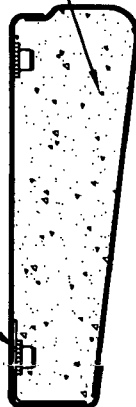
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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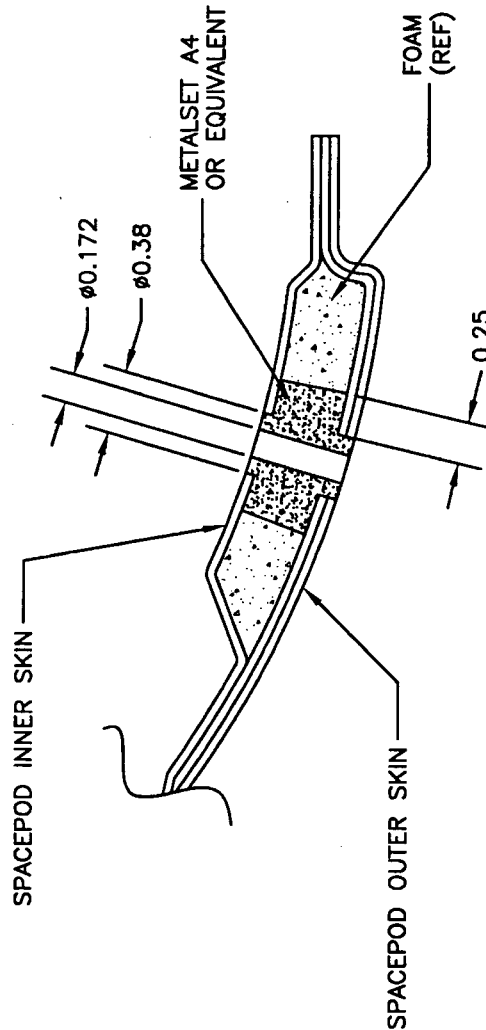
07.02.27

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

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Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

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Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
21/03/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30016 Dwg. Rév.: C Job: 40884 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30026 Dwg. Rév.: C Job: 40966 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30036 Dwg. Rév.: C Job: 40886 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30046 Dwg. Rév.: C Job: 40971 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.


Accepted by:   
Quality department AQ-357



Date: Vendredi, 2007-02-09 09:14:36  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client	: DART Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD BODY	L/H
Numéro Job	: 40966	Numéro Article	: DKC134-0053	
Numéro Soumission	: 2585	Numéro Dessin	: D3188	
Numéro B.A.	:	Projet Numéro	: DKC134	
Cette fois	: 2007-02-09 No. B.V. :	Révision dessin	: <del>B</del> C	
Prsht Rev.	: NC	Matériel	: Fibre 7781 et Résine 411-350	
Prem. fois	: - - Type :	Date Dûe	: 2007-02-16	Qté: 1 Udm: UNITE
Job précédente	: 40923			

Écrit par :   
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Dart Aerospace : D31881M  
 N° de Projet Delastek: DK-362

 Process Sheet Rev.: 00 Création du premier à partir du  
 DKC134-0019

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

 Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MOULE

 Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon  
 le QSI-006.

Date: 9-02-07 Heure Début: Heure Fin: Sceau: DR

3.0 AC0409 Tissu à délaminer Release ply B

 Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)  
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)  
 Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10






 Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert

 Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)  
 Stretchlon 200 poche à vide Vert

Date: Vendredi, 2007-02-09 09:14:37  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40966		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentaire Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-5905-1</u>			
8.0	AC0098	Ruban à gommer jaune #: T/AT-200Y	
Commentaire Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y			
9.0	AAC0443	Fiberglass 12 oz Unidirectional	
Commentaire Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: <u>1-5455-1</u>			
10.0	AAC0633	WR1850 ROVING 18 OZ x 50"	
Commentaire Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s) WR1850 ROVING 18 OZ x 50" N° de Lot: <u>1-5873-1</u>			
11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs TAILLAGE DU MATÉRIEL  Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.  À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.  Date: <u>9-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>HG</u>			
12.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5966-1</u>			
14.0	AAC0673	Fibre de verre Miapoxy 66	
Commentaire Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s) Fibre de verre Miapoxy 66  N° de Lot: <u>1-5958-1</u>			
15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			

Date: Vendredi, 2007-02-09 09:14:37  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxly 66.

Date: 12-02-07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 12-02-07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

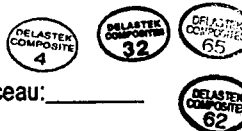
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: 12-02-07 Heure Début: \_\_\_\_\_ Heure fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Vendredi, 2007-02-09 09:14:37  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

19.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date: 13/02/07

Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



20.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

21.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 5921

22.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

13/02/07



Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

23.0

AAC0452

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)  
Polybond B46F

N° de Lot: 1-5865-1

24.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

A l'aide de polybond, coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1

Date: 13/02/07

Sceau: \_\_\_\_\_



Date: Vendredi, 2007-02-09 09:14:37  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon le dessin

Quantité: 1 Date: 14/02/07 Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

27.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 5921

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par  
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core


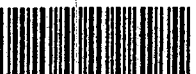


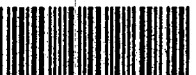









Laisser sécher pendant 2 heures minimum.

Date: 14/02/07 Sceau: Initiales: S. V

Date: Vendredi, 2007-02-09 09:14:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40966		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
30.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-5865-1</u>			
31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation du Polybond. Date: <u>14/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES  Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond. Date: <u>14/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   			
33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE  Faire la poche à vide en appliquant les composantes dans l'ordre suivant:  1- Tissu à délaminer, 2- Feutre de drainage 3- Sac à vide Stretchlon 200  Laisser sécher pendant 2 heures minimum.  Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé Date: <u>14/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:     Curing Début: _____ Curing Fin: _____			



Date: Vendredi, 2007-02-09 09:14:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40966

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6005-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond.

Date: 15/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

15/02/07



38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total: 0.100 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

39.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total: 0.0032 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

40.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART













Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

Date: Vendredi, 2007-02-09 09:14:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40966		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:		Description :
	Quantité: <u>1</u> Date: <u>15/02/07</u> Sceau: _____		
	Quantité: _____ Date: _____ Sceau: _____		
41.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5988-1</u>			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>16/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
44.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS  Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule.  Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9. Date: <u>16/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   			
45.0	POCHE À VIDE 1.	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE À VIDE  Faire la poche à vide en appliquant les composantes dans l'ordre suivant:  1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage			

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 16/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 19/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers. ( Ne pas percer la peau extérieur de la pièce )

Date: 19/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 5921

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.








Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988 - 1











Date: Vendredi, 2007-02-09 09:14:37

Utilisateur: Marc Dubé

**Feuille de Procédé**

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40966		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
50.0	AAC0673	Fibre de verre Miapoxy 66	
<b>Commentaire</b> Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Miapoxy 66  N° de Lot: <u>1-5502-1</u>			
51.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.  Date: <u>22/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
52.0	AAC0448	Spacer N° D2213	
<b>Commentaire</b> Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s) Spacer N° D2213 N° de Lot: <u>1-5949-1</u>			
53.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES  Faire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66  Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous.  Appliquer une pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.  Laisser sécher pendant 4 heures minimum.  Date: <u>22/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   Curing Début: _____ Curing Fin: _____			
54.0	AAC0275	Catalyst N° DDM-9	
<b>Commentaire</b> Qty.: 0.0096 PINTÉ(s)/Unit Total : 0.0096 PINTÉ(s) Catalyst N° DDM-9  N° de Lot: <u>5921</u>			

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40966		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot.: <u>1-5988-1</u>			
56.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>22/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
57.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS  Retirer les pinces et les blocs de bois  Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce selon le dessin.  Laisser sécher pendant 4 heures minimum. Date: <u>22/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   Curing Début: _____ Curing Fin: _____			
58.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART  Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.  Percer les 8 trous des spacers afin de les déboucher. Quantité: <u>1</u> Date: <u>23/02/07</u> Sceau:   Quantité: _____ Date: _____ Sceau: _____			

Date: Vendredi, 2007-02-09 09:14:37  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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59.0	AAC0671	Dupont Primer N° 1104S
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Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S

60.0	AAC0670	Dupont Activator N° 7975S
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Commentaire Qty.: 1.0000 PINTÉ(s)/Unit Total : 1.0000 PINTÉ(s)  
Dupont Activator N° 7975S

61.0	AAC0672	Dupont Reducer N° 12375S
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Commentaire Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S

62.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

~~04/01/2007~~ FEB 26 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART
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Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

~~04/01/2007~~ FEB 26 2007



Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

64.0	AAC0445	Label N° D0600-141
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Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Label N° D0600-141 N° de Lot: \_\_\_\_\_

65.0	AAC0501	Résine Mia-Poxy
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Commentaire Qty.: 0.015 GALLON(s)/Unit Total : 0.015 GALLON(s)  
Résine Mia-Poxy N° de Lot: \_\_\_\_\_

66.0	AAC0502	Durcisseur 95 Pour Résine Mia-Poxy
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Commentaire Qty.: 0.030 PINTÉ(s)/Unit Total : 0.030 PINTÉ(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: \_\_\_\_\_

67.0	AAC0444	Surface Veil
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Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)  
Surface Veil N° de Lot: \_\_\_\_\_

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

68.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-141 sur le spacepod en plaçant un suface veil eu dessous et par dessus le label à l'aide de résine Mia Poxxy selon I.F. # DKC134-0019-13

Date: \_\_\_\_\_ Heure débur: \_\_\_\_\_ Heure fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

69.0 AC0058 Polysoft 1.3 kg # 003012 Sikksens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikksens

N° de Lot: 1-6005-1

70.0 AC0059 Durcisseur Polysoft #004009 Sikksens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)  
Durcisseur Polysoft #004009 Sikksens

71.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikksens

Faire un léger sablage ( grit 220 ) de toutes les surfaces.

Date: 22-02-07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



72.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-5931-2

73.0 AAC0670 Dupont Activation N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)  
Dupont Activation N° 7975S N° de Lot: 1-5931-1

74.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5931-2

75.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

PRÉPARATION DU MATÉRIEL

Masquer le label.

FEB 27 2007



Date: Vendredi, 2007-02-09 09:14:37

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40966Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

76.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

Date: FEB 27 2007

Heure Début: \_\_\_\_\_

Heure Fin: \_\_\_\_\_

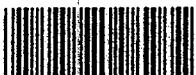
Sceau: \_\_\_\_\_



77.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 28/2/07

Sceau: \_\_\_\_\_

Initiales: \_\_\_\_\_



Emballage QT 1 28/02/07



Date: Mardi, 2007-03-06 09:22:31  
Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.  
 Numéro Job : 40886  
 Numéro Soumission : 2586  
 Numéro B.A. :  
 Cette fois : 2007-03-06 No. B.V. :  
 Prêt Rev. : NC  
 Rem. fois : - - Type :  
 Job précédente : 40698



Nom Dessin : SPACEPOD DOOR  
 Numéro Article : DKC134-0054  
 Numéro Dessin : D3186  
 Projet Numéro : DKC134  
 Révision dessin : B  
 Matériel : Fibre 7781 et Résine 411-350  
 Date Dûe : 2007-02-05 Qté: 1 Udm: UNITE

Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Dart Aerospace : D3186-2  
 N° Delastek Composites DKC-134-0018  
 N° de Projet Delastek: DK-362

# RNC C1206  
 C1209

Process Sheet Rev.: 00 Création du premier à partir du  
 DKC134-0018

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	AC0303	Frekote 44NC
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Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)  
 Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 01/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)  
 Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)  
 Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

ate: Mardi, 2007-03-06 09:22:31  
tilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40886

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

6.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
Stretchlon 200 poche à vide Vert

7.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)  
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-5905-1

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)  
Fiberglass 12 oz Unidirectional N° de Lot: 5433

9.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 28/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 5921

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-6015-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 1/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

Date: Mardi, 2007-03-06 09:22:31

Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40886

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 01/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 01/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

17.0

AAC0324












Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6015-1

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 40886		Numéro Article: DKC134-0054	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.			
Laisse sécher pendant 2 heure.			
Date: <u>2/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
19.0	AAC0452	Polybond B46F	
<b>Commentaire</b> Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s) Polybond B46F N° de Lot: <u>1-5865-1</u>			
20.0	DKC134-0057	Foam Core N° D3186-102 ( Porte D3186-2 )	
<b>Commentaire</b> Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D3186-102 ( Porte D3186-2 ) <u>1-5826-1</u>			
21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES			
Retirez le bagging.			
Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .			
Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )			
Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0024 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.			
Date: <u>2/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE			
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:			
1- Tissu à délaminer			
2- Feutre de drainage			

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40886

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1 heure 1/2 ) afin d'enlever le surplus de polybond

Date: 2/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6015-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 5/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 5/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

Date: Mardi, 2007-03-06 09:22:31

Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40886

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

27.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 5/03/07

Heure Début: \_\_\_\_\_

Heure Fin: \_\_\_\_\_

Sceau: \_\_\_\_\_



Curing Début: \_\_\_\_\_

Curing Fin: \_\_\_\_\_

28.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 6/03/07

Heure Début: \_\_\_\_\_

Heure Fin: \_\_\_\_\_

Sceau: \_\_\_\_\_



29.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TRIMAGE DE FINITION

Trimer la pièce l'aide du gabarit de trimage prévu à cet effet.

Percer les " Latch " et les trous de pentures selon le dessin N° D3186

Date: 6/03/07

Heure Début: \_\_\_\_\_

Heure Fin: \_\_\_\_\_

Sceau: \_\_\_\_\_



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40886

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

30.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-5931-2

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S

N° de Lot: 1-5931-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1-5692-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

MAR 07 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application primer

Laisser sécher pendant 3 heures.

MAR 07 2007

Date: 1 Heure Début:        Heure Fin:        Sceau: 

35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40886

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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36.0	AAC0451	Label N° D0600-142
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Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Label N° D0600-142 N° de Lot: \_\_\_\_\_

37.0	AAC0444	Surface Veil
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Commentaire Qty.: 0.08 VERGE(s)/Unit Total: 0.08 VERGE(s)  
Surface Veil N° de Lot: \_\_\_\_\_

38.0	AAC0501	Résine Mia-Poxy
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Commentaire Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)  
Résine Mia-Poxy N° de Lot: \_\_\_\_\_

N/A

39.0	AAC0502	Durcisseur 95 Pour Résine Mia-Poxy
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Commentaire Qty.: 0.030 PINTE(s)/Unit Total: 0.030 PINTE(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: \_\_\_\_\_

40.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART
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Commentaire Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run: 15.0000Hrs  
FABRICATION GÉNÉRALE DART

Coller le Label N° 0600-142 selon les séquences suivantes:

- 1 Surface Veil
- 2- Label
- 3- Surface Veil

À l'aide de la résine Mia-Poxy selon le dessin D3186.

Laisser sécher pendant 6 heures.

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

41.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens
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Commentaire Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6005-1

42.0	AC0059	Durcisseur Polysoft #004009 Sikkens
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Commentaire Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

43.0	FINITION 3	FINITION PIÈCE DART
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Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.



# Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40886

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération:

Description: *Remwork 16-3-07*



Date: *8-03-07* Heure Début: / Heure Fin: / Sceau: *Remwork: 14-3-07*



44.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: *1-5931-2*

45.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: *1-5931-1*

46.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: *1-5932-2*

47.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

*Nettoyage Qty 1 09-03-07*



MAR 09 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

MAR 14 2007



*Remwork*

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  
APPLICATION DE PRIMER

Masquer le label.

MAR 14 2007



*Remwork*

Appliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application de primer.



MAR 09 2007 Heure Début: / Heure Fin: / Sceau: /

49.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
INSPECTION PIÈCE DART

*21 mars 07*



*RNC C1206 C1209*


*Emballage QT 1*

*21/3/07*



<b>DELASTEI</b>	<b>Rapport de non-conformité - plaintes clients (RNC)</b>				<b>DÉTECTION</b>		<b>No. R.N.C.</b>										
					<input checked="" type="checkbox"/> Delastek <input type="checkbox"/> Client	C1209											
<b>AQ-15</b> rev.3	FOURNISSEUR DKC		CLIENT DART		Cause		INSPECTÉ PAR (date)										
NUMÉRO DE DESSIN D3186	NO. RÉVISION C	NO. TRAVAIL 40886	NUMÉRO DE PIÈCE D3186-2		DELAMINAGE		NICOLAS ST-ARNAUD										
NUMÉRO DE COMMANDE	NOM DU PRODUIT SPACEPOD DOOR	NUMÉRO SÉRIE N/A	GARANTIE <input type="checkbox"/> OUI <input checked="" type="checkbox"/> NON		Bon de livraison / No. RMA N/A		Responsabilité (Département) LAMINAGE										
<div>2</div> <b>DESCRIPTION DE LA NON CONFORMITÉ</b>																	
<b>BULLE D'AIR DANS LES PIÈCES</b>					<b>impacts réels et potentiels</b>												
					<table border="1"> <thead> <tr> <th></th> <th>non</th> <th>oui</th> </tr> </thead> <tbody> <tr> <td>Effets sur d'autres produits en inventaire ?</td> <td>X</td> <td></td> </tr> <tr> <td>Effets sur d'autres produits en cours ?</td> <td>X</td> <td></td> </tr> <tr> <td>Effets sur d'autres produits déjà livrés ?</td> <td>X</td> <td></td> </tr> <tr> <td>Autre effets réels ou potentiel ?</td> <td>X</td> <td></td> </tr> </tbody> </table>				non	oui	Effets sur d'autres produits en inventaire ?	X		Effets sur d'autres produits en cours ?	X		Effets sur d'autres produits déjà livrés ?
	non	oui															
Effets sur d'autres produits en inventaire ?	X																
Effets sur d'autres produits en cours ?	X																
Effets sur d'autres produits déjà livrés ?	X																
Autre effets réels ou potentiel ?	X																
<b>DISPOSITION DU PRODUIT NON CONFORME</b>					Si oui (détails)												
MASSUAGE + nettoyage 10 min Nettoyage Qty 1 20-03-07 5 min MAR 20 2007 MAR 16 2007 10 min 10 min Réparation selon les méthodes de travail Percer et injecter 15 min #hot 1-6024-1 temps 15 min Collage 20 min					coût associé:												
<input type="checkbox"/> 1- Accepté tel quel <input type="checkbox"/> 2- Retouche <input checked="" type="checkbox"/> 3- Réparation <input type="checkbox"/> 4- Dérogation <input type="checkbox"/> 5- Rebut <input type="checkbox"/> 6- Autres					<b>COÛT DE LA NON CONFORMITÉ</b>												
<b>ACTION CORRECTIVE OU PRÉVENTIVE REQUISE</b>					MATIÈRE PREMIÈRE: - \$												
OUI <input type="checkbox"/> Numéro:   Date:   NON <input checked="" type="checkbox"/>					EXPERTISE: 35.00 \$												
Conformité après correction (si le produit a été corrigé pour le rendre conforme) <input type="checkbox"/> n/a <input checked="" type="checkbox"/> OUI <del>NON</del> REF C4300					MAIN D'ŒUVRE - \$												
Approuvé par: <i>Nicolas St-Arnaud</i> Estampe: <i>N.S.</i> Complété par: NICOLAS ST-ARNAUD					TRANSPORT - \$												
13-mars-07   13-mars-07					AUTRE (S) - \$												
					CANS TOTAL: 35.00 \$												
					DATE DE RÉCEPTION (SAV)   DATE D'EXPÉDITION (SAV)												
					N/A   N/A												

21/03/07

		<b>Rapport de non-conformité - plaintes clients (RNC)</b>				<b>DÉTECTION</b>		<b>No. R.N.C.</b>	
<b>AQ-15</b> rev.3		FOURNISSEUR DKC		CLIENT DART		<input checked="" type="checkbox"/> Delastek  <input type="checkbox"/> Client		C1206	
NUMÉRO DE DESSIN DKC-134-0017		NO. RÉVISION		NO. TRAVAIL 40886		NUMÉRO DE PIÈCE D3186-2		INSPECTÉ PAR (date) NICOLAS ST-ARNAUD	
NUMÉRO DE COMMANDE		NOM DU PRODUIT D3186-2		NUMÉRO SÉRIE N/A		GARANTIE <input type="checkbox"/> OUI <input checked="" type="checkbox"/> NON		Cause LAMINAGE	
						Bon de livraison / No. RMA N/A		Responsabilité (Département) LAMINAGE	
						N/A		N/A	
<b>2 DESCRIPTION DE LA NON CONFORMITÉ</b>									
BULLE D'AIR DANS LES PIÈCES, AUSSI POUR LA JOB 40884						<b>impacts réels et potentiels</b>			
						Effets sur d'autres produits en inventaire ? <input checked="" type="checkbox"/> non <input type="checkbox"/> oui			
						Effets sur d'autres produits en cours ? <input checked="" type="checkbox"/> non <input type="checkbox"/> oui			
						Effets sur d'autres produits déjà livrés ? <input checked="" type="checkbox"/> non <input type="checkbox"/> oui			
						Autre effets réels ou potentiel ? <input checked="" type="checkbox"/> non <input type="checkbox"/> oui			
						Si oui (détails)			
<b>DISPOSITION DU PRODUIT NON CONFORME</b>									
<i>Perçer et injecter résine 15 min #Pot: 1-6024-1</i> RÉPARATION SELON LES MÉTHODES DE TRAVAIL Primer MAR 16 2007 16 mins Temps 15 min Sablage 20 min									
<input type="checkbox"/> 1- Accepté tel quel <input type="checkbox"/> 2- Retouche <input checked="" type="checkbox"/> 3- Réparation <input type="checkbox"/> 4- Dérogation <input type="checkbox"/> 5- Rebut <input type="checkbox"/> 6- Autres						coût associé:			
<b>ACTION CORRECTIVE OU PREVENTIVE REQUISE</b>						<b>COÛT DE LA NON CONFORMITE</b>			
OUI <input type="checkbox"/> Numéro: Date: NON <input checked="" type="checkbox"/>						MATIERE PREMIERE: - \$			
Conformité après correction (si le produit a été corrigé pour le rendre conforme) <input type="checkbox"/> n/a <input type="checkbox"/> oui						EXPERTISE: 35.00 \$			
Approuvé par: Estampe Complété par						MAIN D'ŒUVRE - \$			
13-mars-07 N.S. 13-mars-07						TRANSPORT - \$			
						AUTRE (S) - \$			
						CANS TOTAL: 35.00 \$			
						DATE DE RECEPTION (SAV) DATE D'EXPEDITION (SAV)			
						N/A N/A			

Date: Wednesday, 3/7/2007 4:32:01 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31082C		
Estimate Number	: 12635		
P.O. Number	: N/A	Part Number	: D31863
This Issue	: 3/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3186 REV.D
First Issue	: 3/7/2007	Project Number	: N/A
Previous Run	: 31081C	Drawing Revision	: D
		Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31082C01	SPACEPOD DOOR LH
-----	----------	------------------

30016



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ml 07/04/10

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/04/11

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

① 07/04/11

Job Completion



U 07-21-16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 02/04/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

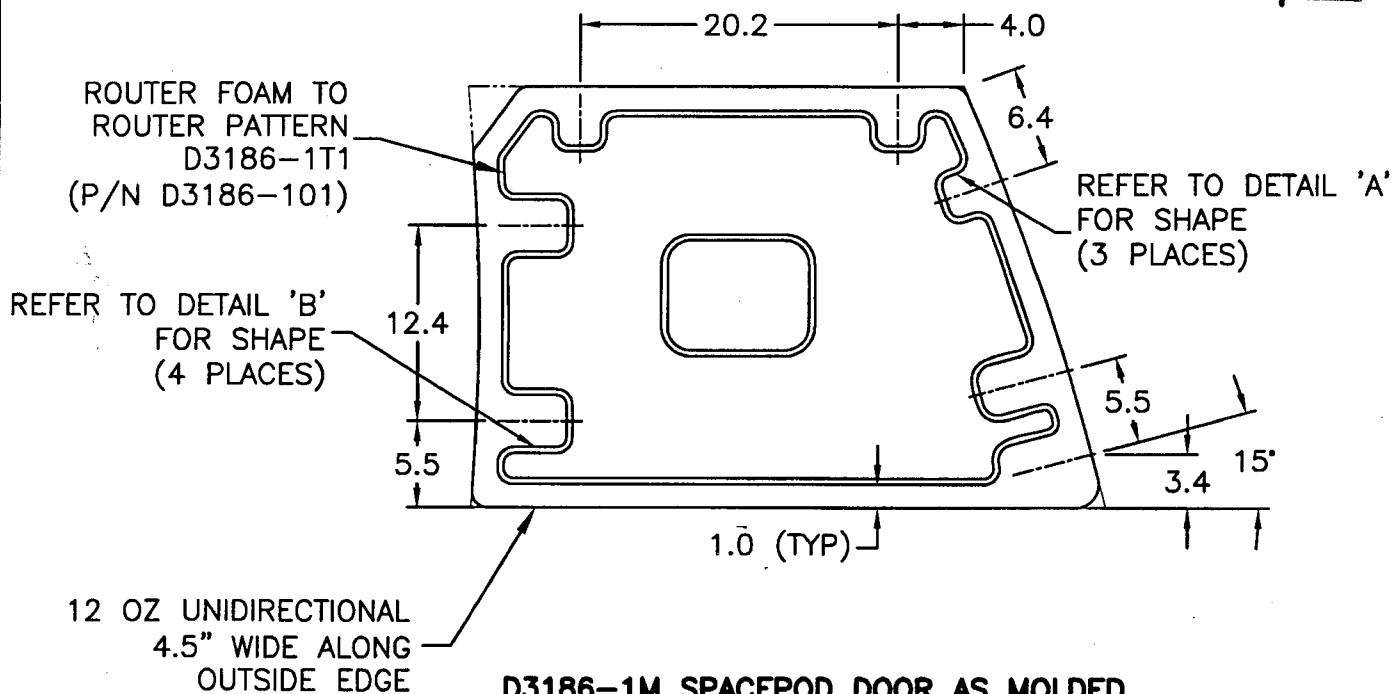
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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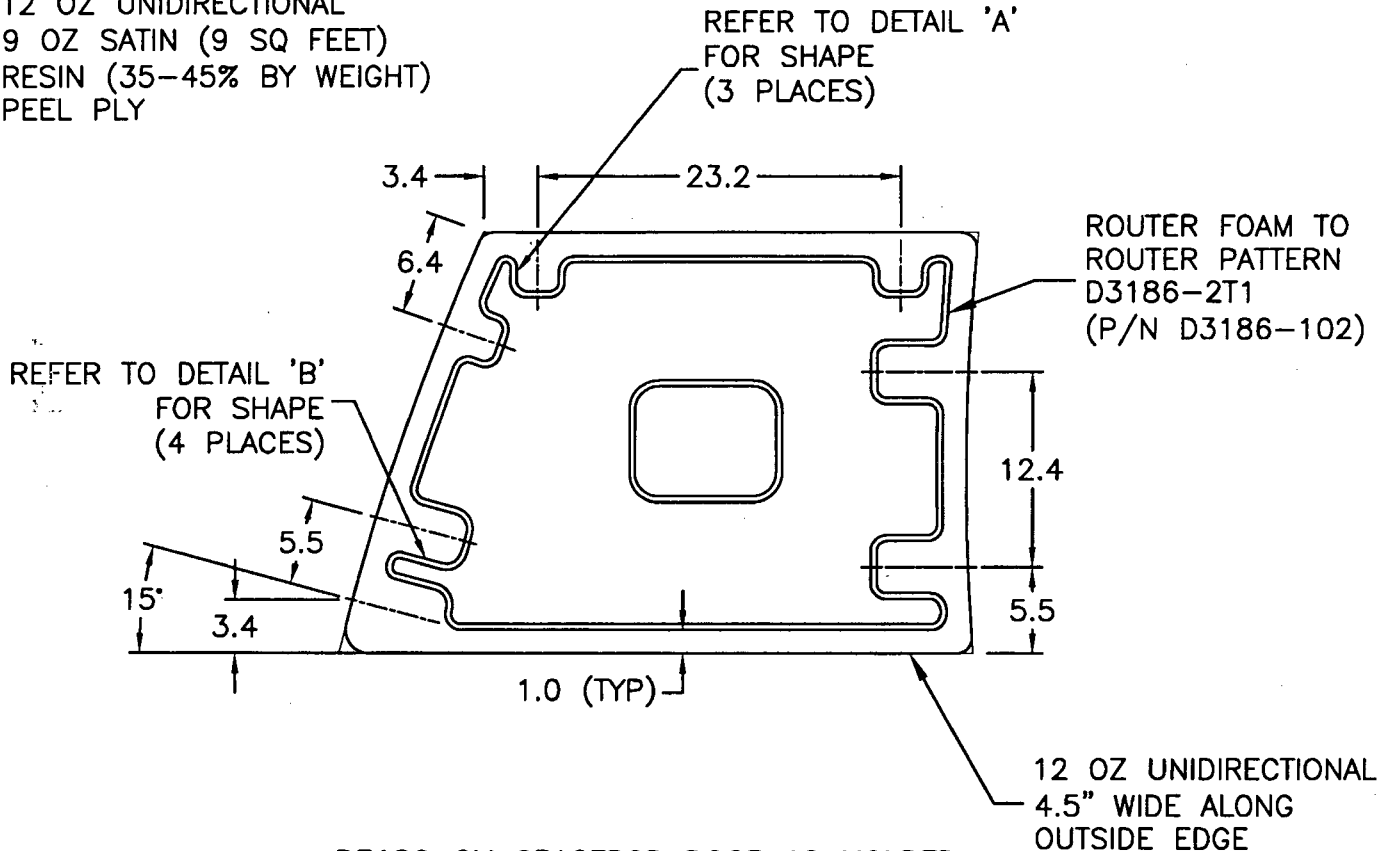
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0.
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBMIT TO AMENDMENT

A. HOLT/NO. 6

1.0/NO. 6

NO. 31082C

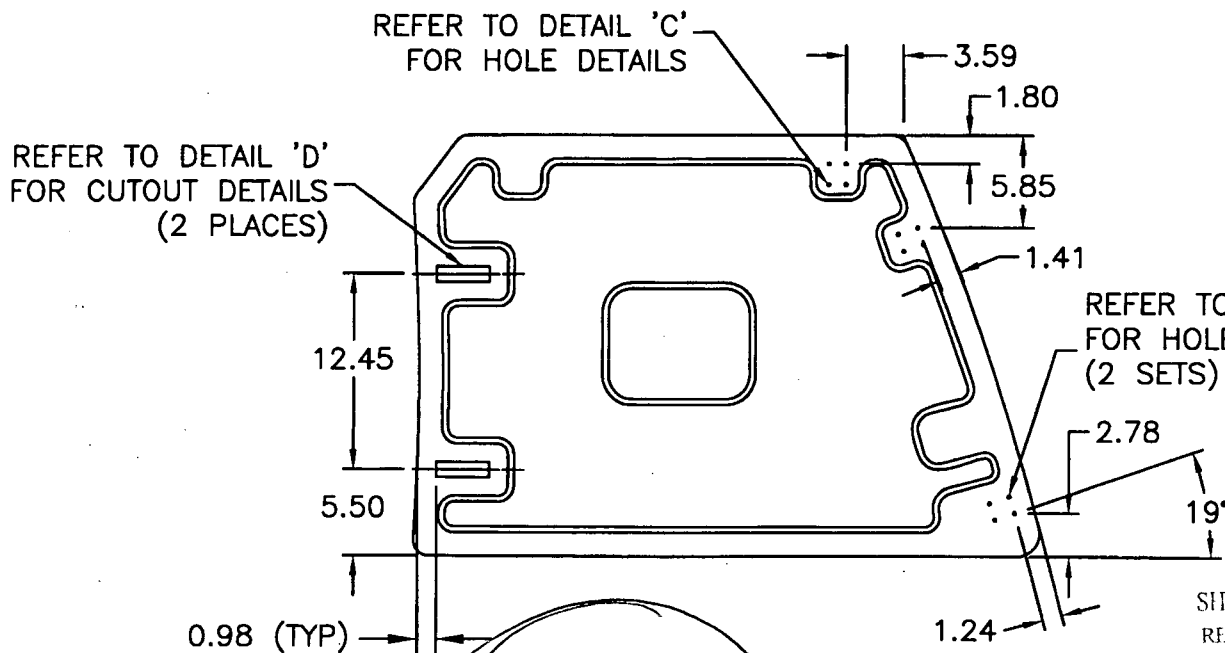
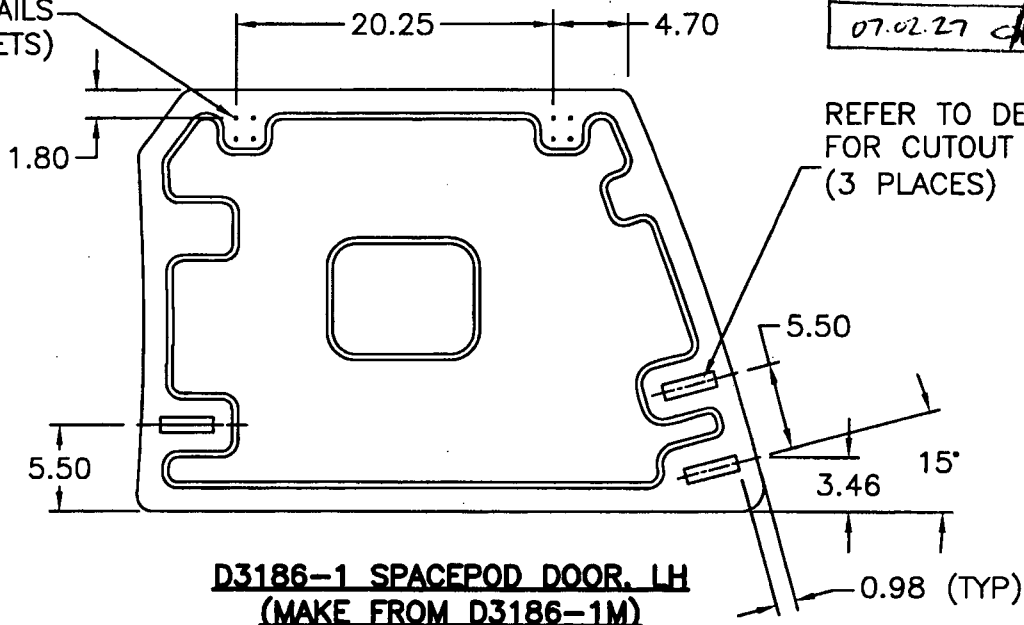
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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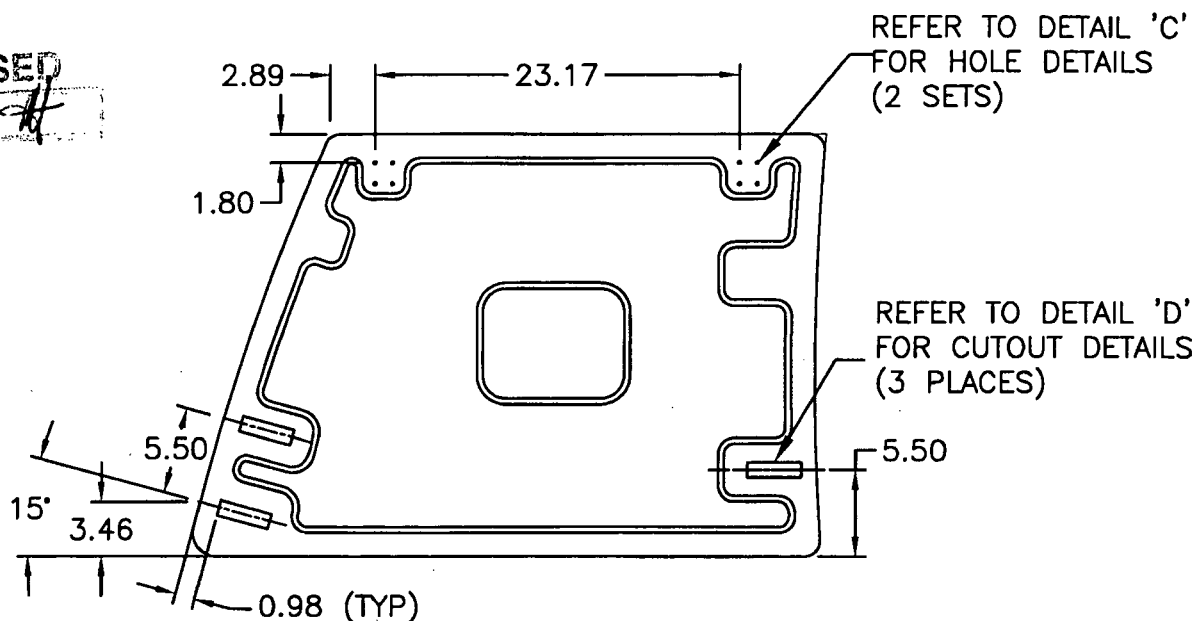




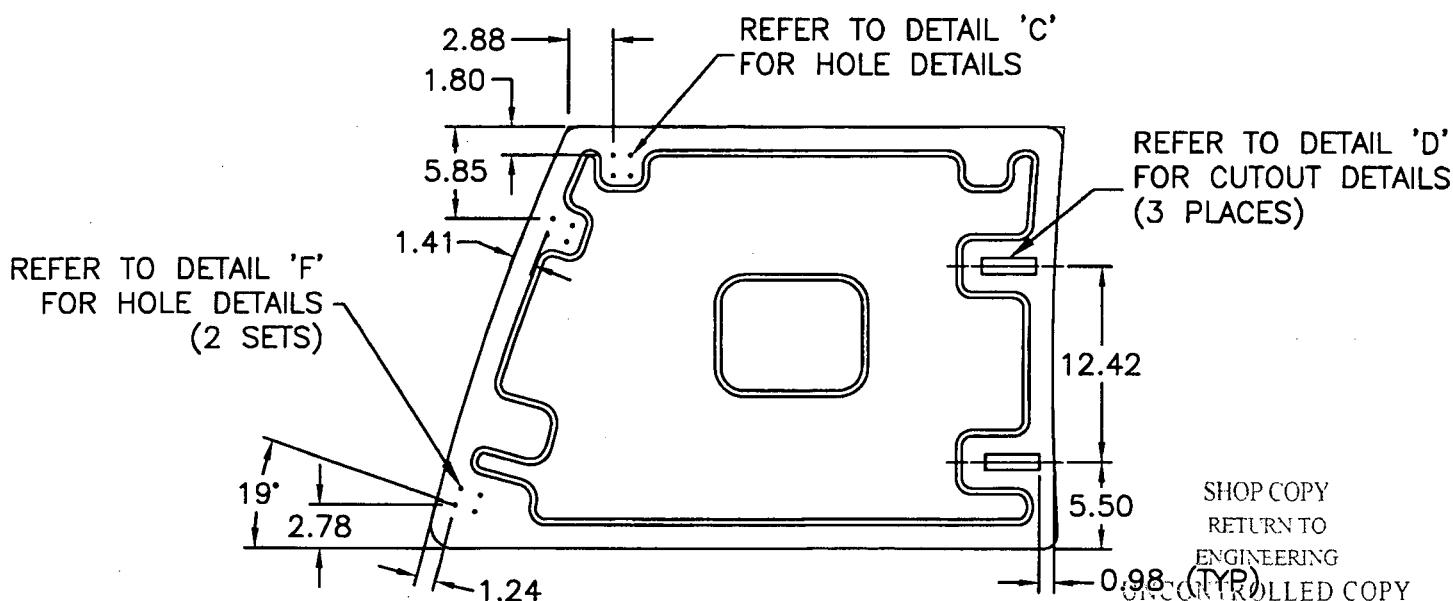
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

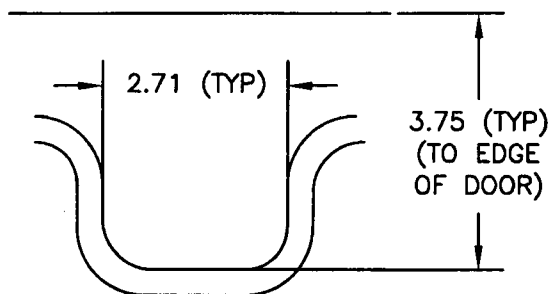
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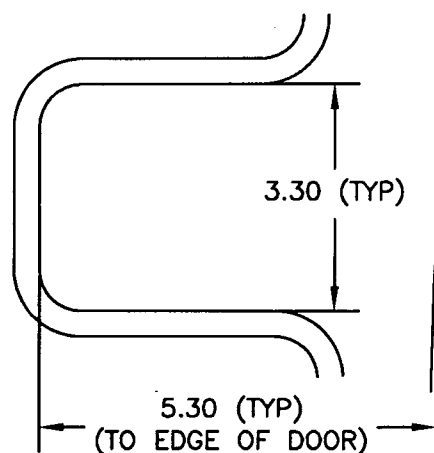
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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



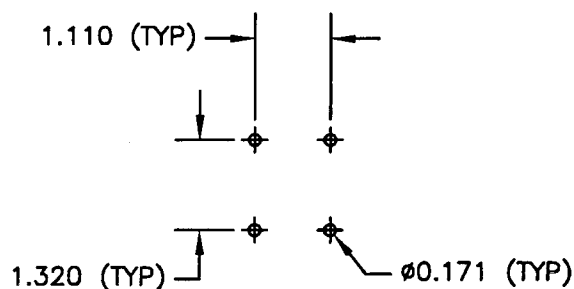
**DETAIL A**



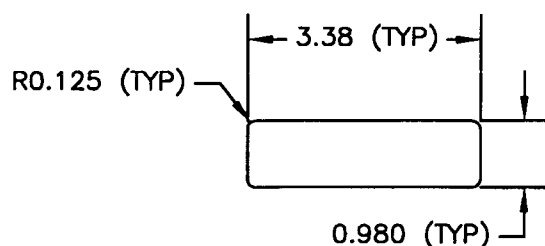
**DETAIL B**

**RELEASED**

07.02.22 [Signature]

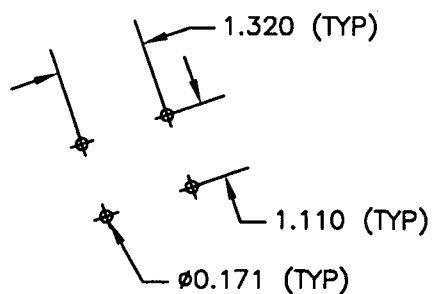


**DETAIL C**

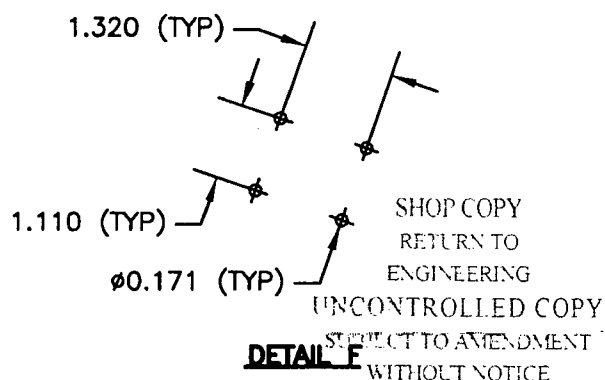


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

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Date: Wednesday, 12/20/2006 1:44:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 30016		
Estimate Number	: 12598		
P.O. Number	: N/A	Part Number	: D31861M
This Issue	: 12/20/2006 S.O. No. : N/A	Drawing Number	: D3186 REV <i>B/C</i> <i>LE</i> 07.01.18
Prsht Rev.	: NC	Project Number	: N/A <i>LE</i>
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: <i>B/C</i> 07.01.18
Previous Run	: 30015	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 1/30/2007
Checked & Approved By	: <i>[Signature]</i> 06/12/20	Qty:	1 Um: Each
Comment	: Est Rev A New Issue 06-12-04 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

*C Lote 1/2/21 ①*

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

*12/23/23*  
*[Signature]*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**m 07/03/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LP Date: 07/04/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30016

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Done 12/16/06* (4)

Job Completion



*U Done 12/16/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

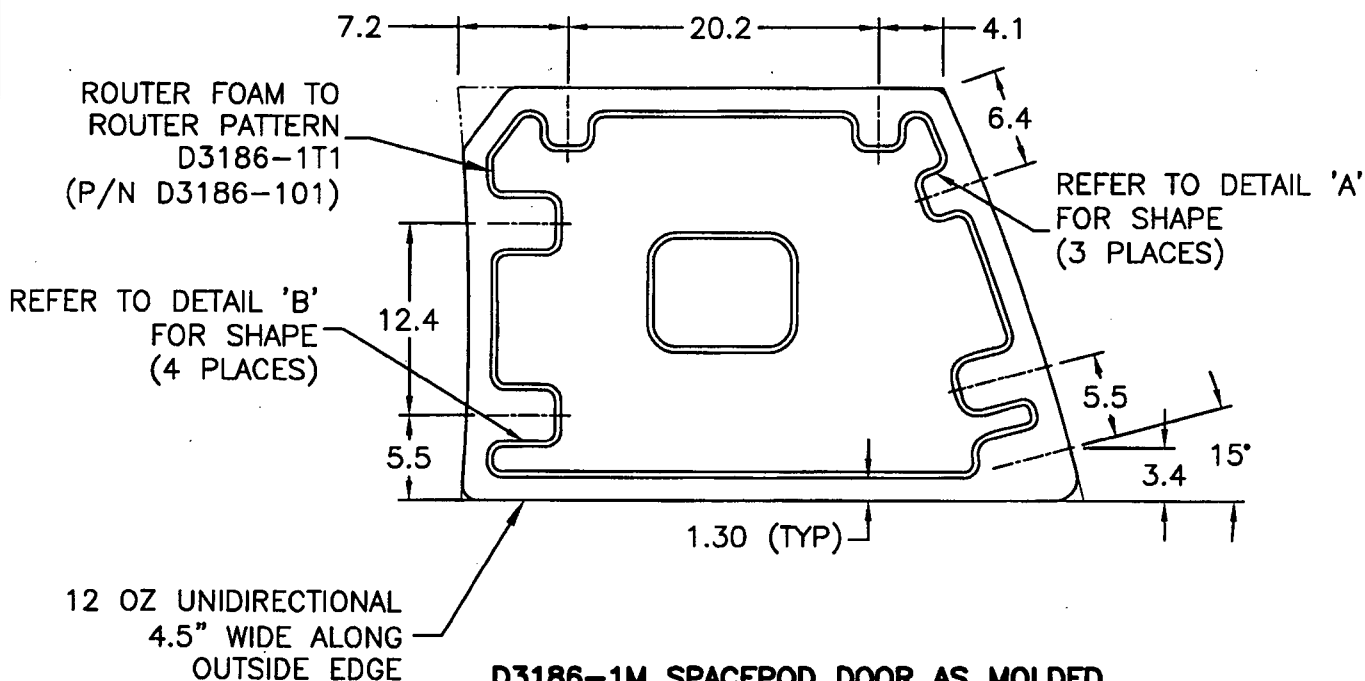
**NOTE:** Date & initial all entries

**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**  
06.12.22 H**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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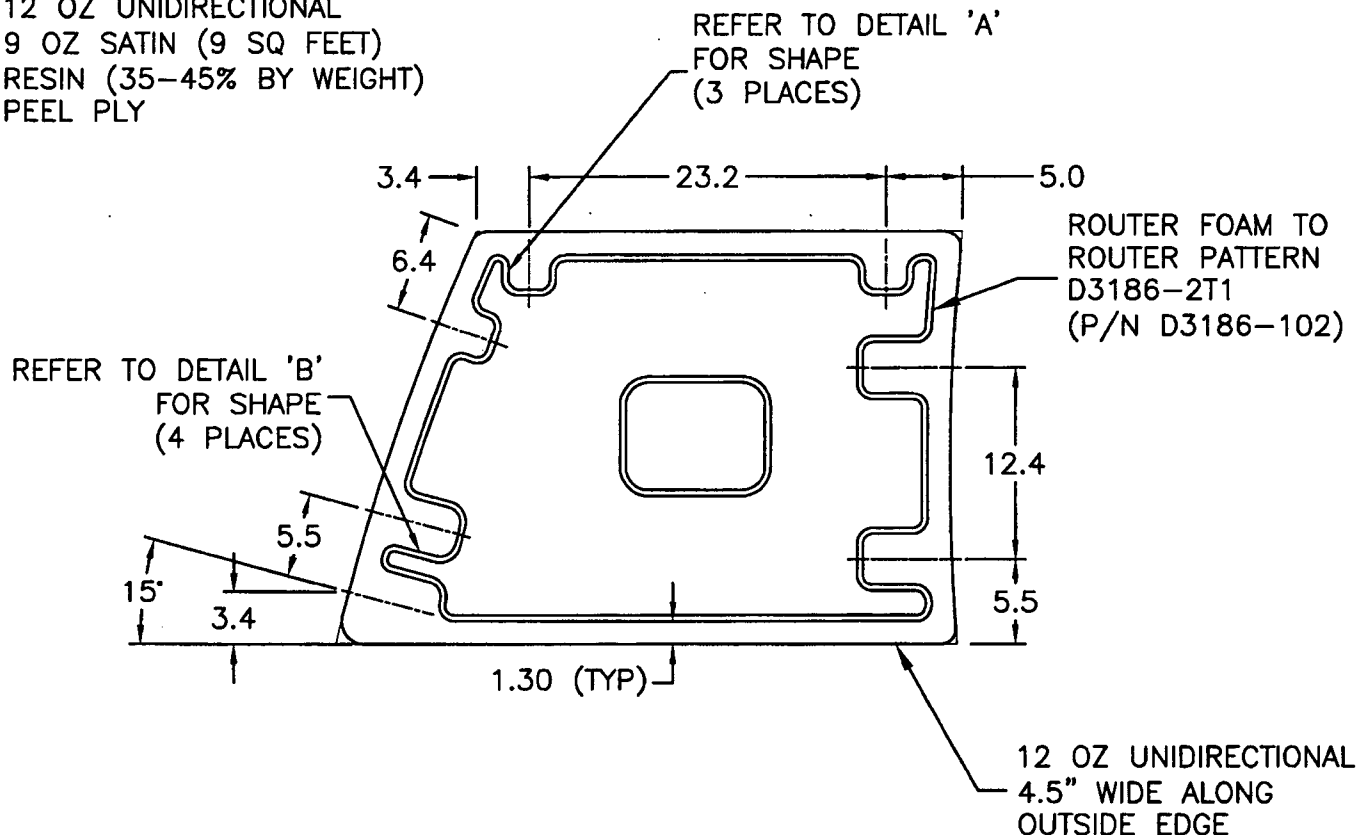
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**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**  
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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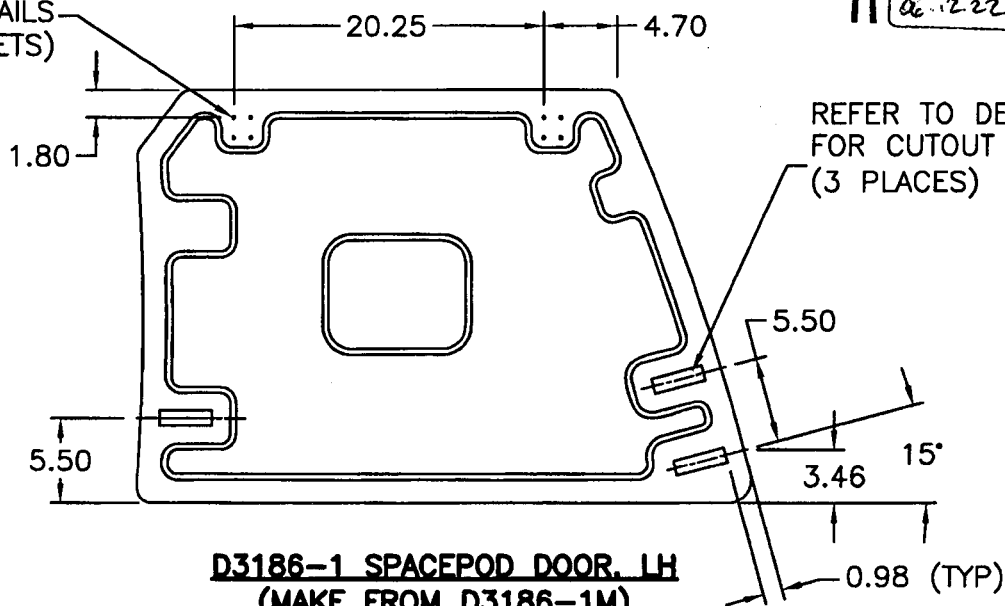
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**DART**

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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

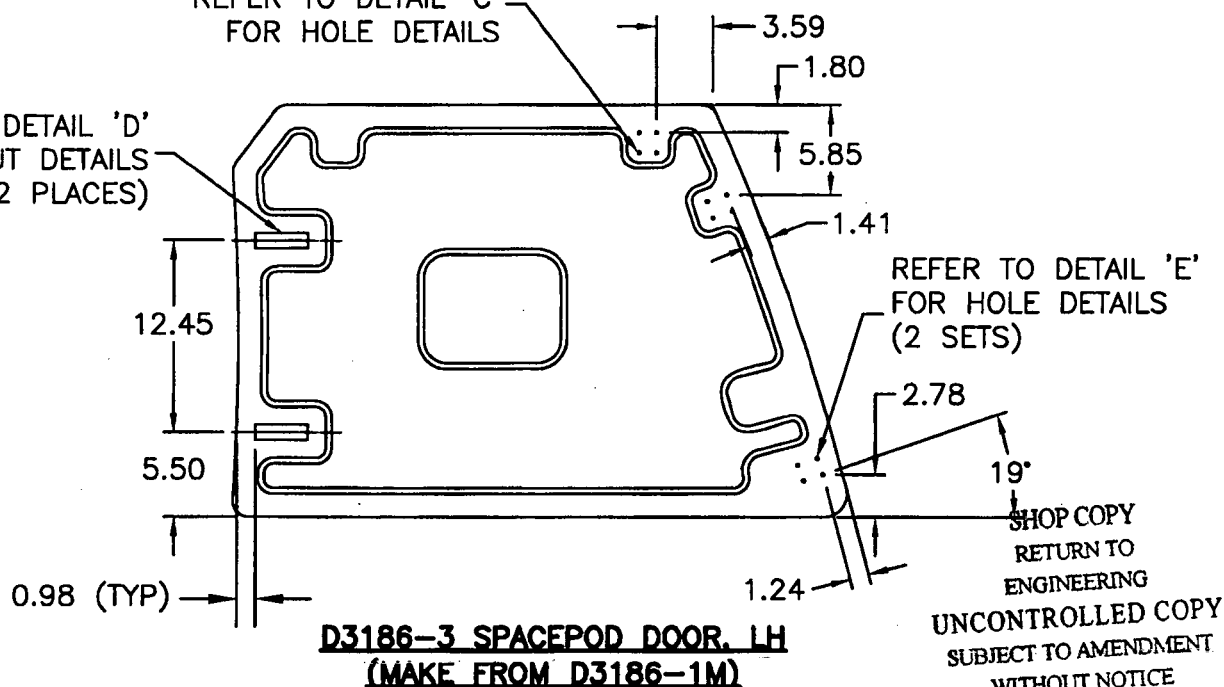
REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



**RELEASED**  
*ai-1222*

REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)



**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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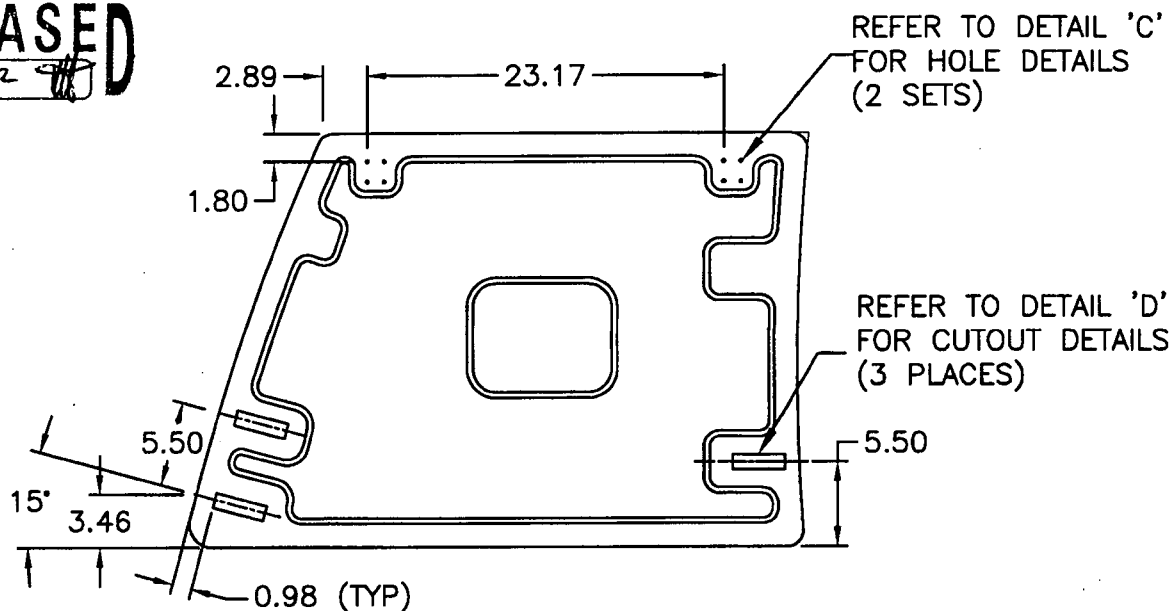
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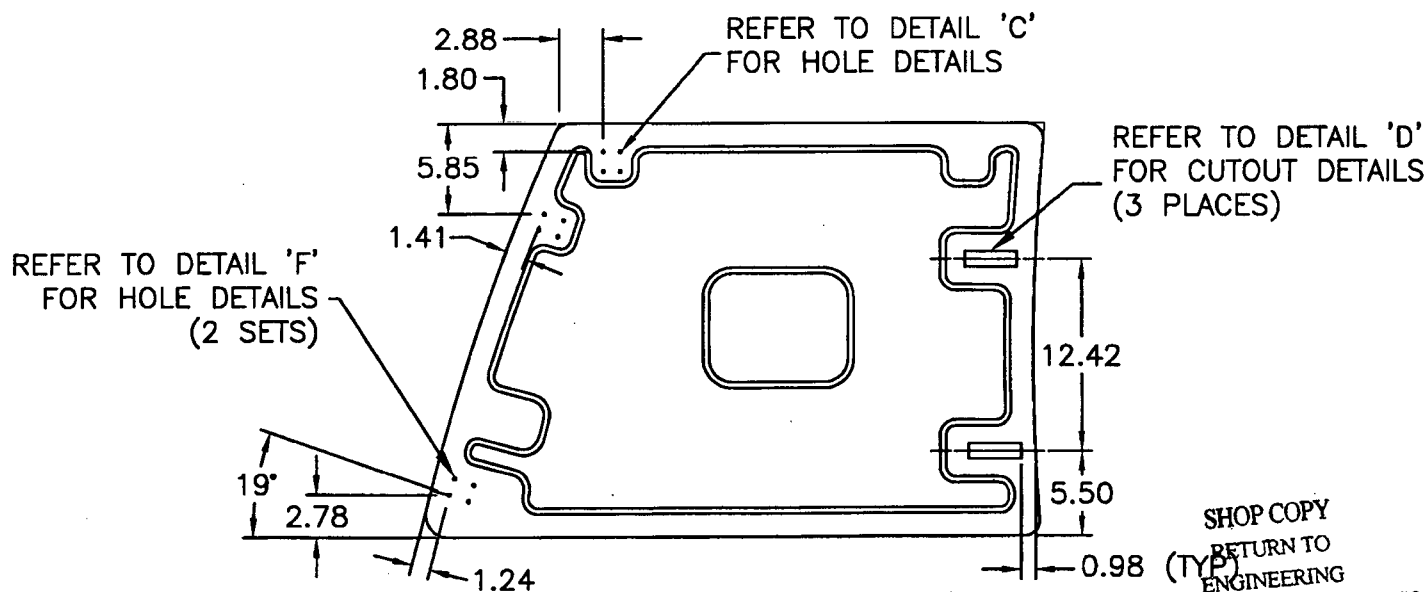


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED  
06.12.22



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

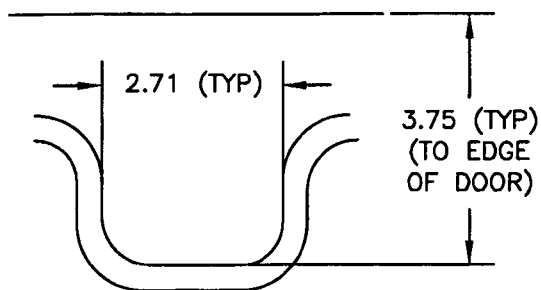
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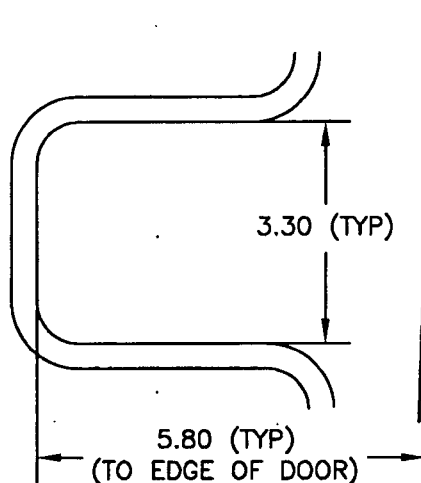
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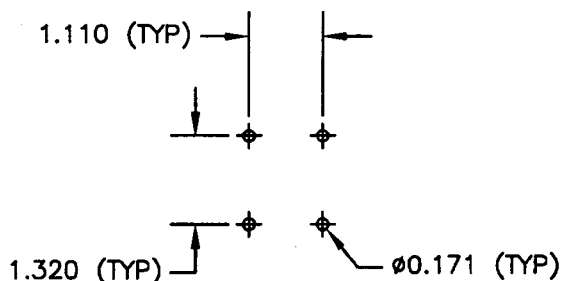
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



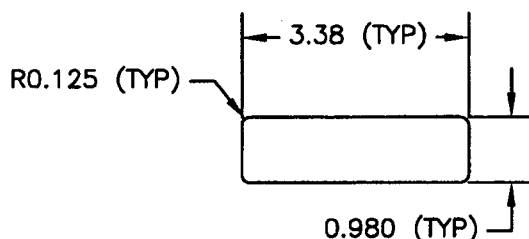
**DETAIL A**



**DETAIL B**

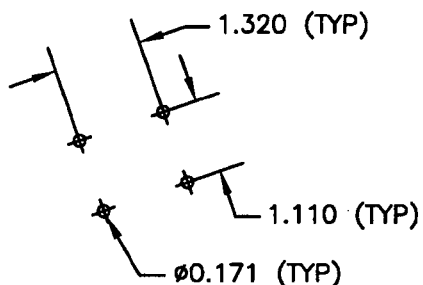


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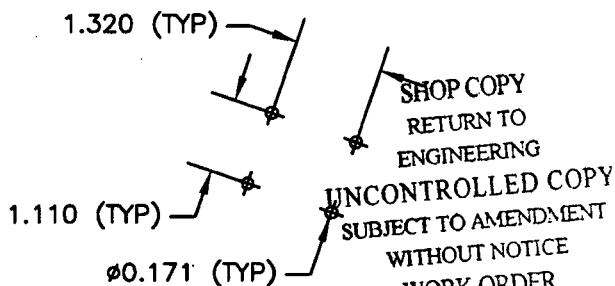


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
06.12.22

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11759
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
21/03/07	21/12/06	5092	C. Lavoie	PO000002767			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30016 Dwg. Rév.: C Job: 40884 67/3/23			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30026 Dwg. Rév.: C Job: 40966			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30036 Dwg. Rév.: C Job: 40886			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30046 Dwg. Rév.: C Job: 40971			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

*Paul St. Michel*



Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2007-03-06 09:20:49  
Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.	Nom Dessin : SPACEPOD DOOR
Numéro Job : 40884	Numéro Article : DKC134-0052
Numéro Soumission : 2584	Numéro Dessin : D3186
Numéro B.A. :	Projet Numéro : DKC134
Date fois : 2007-03-06 No. B.V. :	Révision dessin : B
Prsht Rev. : NC	Matériel : Fibre 7781 et Résine 411-350
rem. fois : - - Type :	Date Dûe : 2007-02-05 Qté: 1 Udm: UNITE
Job précédente : 40696	

Écrit par : \_\_\_\_\_  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N° de pièce Dart Aerospace : D3186-1  
N° Delastek Composites DKC-134-0017  
N° de Projet Delastek: DK-362

Process Sheet Rev.: 00 Création du premier à partir du  
DKC134-0017

# RNC C120G  
C1210

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentaire Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE  Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.  Date: 01/03/07 Heure Début: _____ Heure Fin: _____ Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentaire Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentaire Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentaire Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Feutre de drainage N° Airweave N 10		

Date: Mardi, 2007-03-06 09:20:49  
Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40884

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
Stretchlon 200 poche à vide Vert

7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)  
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-5905-1

8.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

9.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)  
Fiberglass 12 oz Unidirectional N° de Lot: 5453

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 28/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

11.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0080 PINTE(s)/Unit Total : 0.0080 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 5921

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6015-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 1/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

Date: Mardi, 2007-03-06 09:20:49  
Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40884

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

14.0	LAMINAGE.	LAMINAGE PIÈCE DART
------	-----------	---------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 01/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 01/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

16.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 5921

17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6015-1

Date: Mardi, 2007-03-06 09:20:49

Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40884

Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 2/23/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



19.0 DKC134-0056 Foam Core N° D3186-101 ( Porte D3186-1 )

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-101 ( Porte D3186-1 )

1-5826-1

20.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F

N° de Lot: 1-5865-1

1-5865-1

21.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0024 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 2/23/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



22.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage



Date: Mardi, 2007-03-06 09:20:49

Utilisateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40884Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond.

Date: 2/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6015-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 5/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 5/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

Date: Mardi, 2007-03-06 09:20:49

Installateur: Sylvie Hamel

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40884

Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 5/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci

Date: 6/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer la pièce à l'aide du gabarit de trimage prévu à cet effet.

Percer les trous de Hatch et de pentures selon le dessin N° D3186

Date: 6/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



Date: Mardi, 2007-03-06 09:20:49

Utilisateur: Sylvie Hamel

**Feuille de Procédé**

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 40884

Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

30.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S 1-5931-2

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S 1-5931-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S 1-5692-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

MAR 07 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PEINTURE / PRIMER DARTAppliquer la première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. #  
Application du primer.

Laisser sécher pendant 3 heures.

MAR 07 2007

Date: Heure Début: Heure Fin: Sceau:



35.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DARTSabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du  
primer.

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40884

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description:

36.0 AAC0446 Label N° D0600-145

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Label N° D0600-145 N° de Lot: \_\_\_\_\_

37.0 AAC0444 Surface Veil

Commentair Qty.: 0.08 VERGE(s)/Unit Total: 0.08 VERGE(s)  
Surface Veil N° de Lot: \_\_\_\_\_

N/A

38.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)  
Résine Mia-Poxy N° de Lot: \_\_\_\_\_

39.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total: 0.030 PINTE(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: \_\_\_\_\_

40.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run: 15.0000Hrs  
FABRICATION GÉNÉRALE DART

Coller le Label N° 0600-145 selon les séquences suivantes:

- 1 Surface Veil
- 2- Label
- 3- Surface Veil

À l'aide de la résine Mia-Poxy selon le dessin D3186.

Laisser sécher pendant 6 heures.

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

41.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

42.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total: 0.050 KIT(s)  
MASTIC POLYSTOP SIKKENS 3AR591

43.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6005-1

44.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs  
FINITION GÉNÉRALE

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 40884

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 08-03-07 Heure Début: / Heure Fin: / Sceau:



Rework  
14-3-07



45.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-5931-2

Rework  
19-3-07



46.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-5931-1

47.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5932-2

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Nettoyage Qty 1 09-03-07



MAR 09 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

MAR 14 2007



Rework

49.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  
APPLICATION DE PRIMER

Masquer le label

MAR 14 2007



Rework

Appliquer la deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G. #

Application du primer

MAR 09 2007

Date: / Heure Début: / Heure Fin: / Sceau:



50.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
INSPECTION PIÈCE DART

21 mars 07





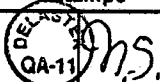



RNC C1206  
RNC C1210



Emballage QT 1

21 mars 07

<b>DELASTEI</b>	<b>Rapport de non-conformité - plaintes clients (RNC)</b>				<b>DÉTECTION</b>		<b>No. R.N.C.</b>										
					<input checked="" type="checkbox"/> Delastek <input type="checkbox"/> Client		C1210										
<b>AQ-15</b> rev.3	<b>FOURNISSEUR</b>		<b>CLIENT</b>		<b>INSPECTÉ PAR (date)</b>												
	DKC		DART		Cause												
<b>NUMÉRO DE DESSIN</b>	<b>NO. RÉVISION</b>	<b>NO. TRAVAIL</b>	<b>NUMÉRO DE PIÈCE</b>		DELAMINAGE												
D3186	C	40886	D3186-1														
<b>NUMÉRO DE COMMANDE</b>	<b>NOM DU PRODUIT</b>	<b>NUMÉRO SÉRIE</b>	<b>GARANTIE</b>		<b>Bon de livraison / No. RMA</b>		<b>Responsabilité (Département)</b>										
	SPACEPOD DOOR	N/A	<input type="checkbox"/> OUI <input checked="" type="checkbox"/> NON		N/A	N/A	LAMINAGE										
<b>2</b>	<b>DESCRIPTION DE LA NON CONFORMITÉ</b>																
BULLE D'AIR DANS LES PIÈCES					<b>impacts réels et potentiels</b>												
					<table border="1"> <thead> <tr> <th></th> <th>non</th> <th>oui</th> </tr> </thead> <tbody> <tr> <td>Effets sur d'autres produits en inventaire ?</td> <td>X</td> <td></td> </tr> <tr> <td>Effets sur d'autres produits en cours ?</td> <td>X</td> <td></td> </tr> <tr> <td>Effets sur d'autres produits déjà livrés ?</td> <td>X</td> <td></td> </tr> <tr> <td>Autre effets réels ou potentiel ?</td> <td>X</td> <td></td> </tr> </tbody> </table>				non	oui	Effets sur d'autres produits en inventaire ?	X		Effets sur d'autres produits en cours ?	X		Effets sur d'autres produits déjà livrés ?
	non	oui															
Effets sur d'autres produits en inventaire ?	X																
Effets sur d'autres produits en cours ?	X																
Effets sur d'autres produits déjà livrés ?	X																
Autre effets réels ou potentiel ?	X																
DISPOSITION DU PRODUIT NON CONFORME					Si oui (détails)												
<i>Percer et injecter résine 15 min Pot 1-6024-1</i> <b>RÉPARATION SELON LES MÉTHODES DE TRAVAIL</b> <i>Temps 15 min</i>  <i>Primer MAR 20 2007</i>  <i>10 mins</i> <i>Nettoyage qty 1 20-03-07</i>  <i>Sablage 20 min</i> 					coût associé:												
<input type="checkbox"/> 1- Accepté tel quel <input type="checkbox"/> 2- Retouche <input checked="" type="checkbox"/> 3- Réparation <input type="checkbox"/> 4- Dérogation <input type="checkbox"/> 5- Rebut <input type="checkbox"/> 6- Autres																	
<b>ACTION CORRECTIVE OU PRÉVENTIVE REQUISE</b>					<b>COÛT DE LA NON CONFORMITÉ</b>												
OUI <input type="checkbox"/> Numéro:      Date:      NON <input checked="" type="checkbox"/>					<b>MATIERE PREMIERE:</b> - \$												
Conformité après correction (si le produit a été corrigé pour le rendre conforme)					<b>EXPERTISE:</b> 35.00 \$												
<input type="checkbox"/> n/a <input checked="" type="checkbox"/> OUI <del>NON</del> REF: 61206					<b>MAIN D'ŒUVRE</b> - \$												
Approuvé par: <i>Nicolas St-Arnaud</i> Estampe:  Complété par:					<b>TRANSPORT</b> - \$												
21 mars 07					<b>AUTRE (S)</b> - \$												
NICOLAS ST-ARNAUD 15-mars-07					<b>CANS TOTAL:</b> 35.00 \$												
					<b>DATE DE RECEPTION (SAV)</b>		<b>DATE D'EXPEDITION (SAV)</b>										
					N/A		N/A										

		<b>Rapport de non-conformité - plaintes clients (RNC)</b>		<b>DÉTECTION</b>		<b>No. R.N.C.</b>	
<b>AQ-15</b> rev. 3		FOURNISSEUR DKC		CLIENT DART		Delastek <input type="checkbox"/> Client	
C1206		INSPECTÉ PAR (date)		Cause		NICOLAS ST-ARNAUD	
NUMÉRO DE DESSIN DKC-134-0017		NO. RÉVISION		NO. TRAVAIL 40886		NUMÉRO DE PIÈCE D3186-2	
LAMINAGE		Responsabilité (Département)		Bon de livraison / No. RMA		LAMINAGE	
NUMÉRO DE COMMANDE		NOM DU PRODUIT D3186-2		NUMÉRO SÉRIE N/A		GARANTIE <input type="checkbox"/> OUI <input checked="" type="checkbox"/> NON	
2		DESCRIPTION DE LA NON CONFORMITÉ		impacts réels et potentiels		non    oui	
		BULLE D'AIR DANS LES PIÈCES, AUSSI POUR LA JOB 40884		Effets sur d'autres produits en inventaire ?		X	
				Effets sur d'autres produits en cours ?		X	
				Effets sur d'autres produits déjà livrés ?		X	
				Autre effets réels ou potentiel ?		X	
				Si oui (détails)			
		DISPOSITION DU PRODUIT NON CONFORME		coût associé:			
		Percer et injecter résine 15 min F.R. et: 1-6024-1 RÉPARATION SELON LES MÉTHODES DE TRAVAIL Temps 15 min Nettoyage + Primer MAR 14 2007 16 Sablage: 20 min 0 min		COÛT DE LA NON CONFORMITE			
		<input type="checkbox"/> 1- Accepté tel quel <input type="checkbox"/> 2- Retouche <input checked="" type="checkbox"/> 3- Réparation <input type="checkbox"/> 4- Dérogation <input type="checkbox"/> 5- Rebut <input type="checkbox"/> 6- Autres		MATIERE PREMIERE:		- \$	
		ACTION CORRECTIVE OU PRÉVENTIVE REQUISE		EXPERTISE:		35.00 \$	
		OUI <input type="checkbox"/> Numéro:    Date:    NON <input checked="" type="checkbox"/>		MAIN D'ŒUVRE		- \$	
		Conformité après correction (si le produit a été corrigé pour le rendre conforme)		TRANSPORT		- \$	
		Approuvé par:    Estampe    Complété par		AUTRE (S)		- \$	
		Nicolas St-Arnaud    N.S.    N.S.    Nicolas St-Arnaud		CANS TOTAL:		35.00 \$	
		13-mars-07    13-mars-07		DATE DE RECEPTION (SAV)		DATE D'EXPEDITION (SAV)	
				N/A		N/A	

Date: Wednesday, 12/20/2006 1:45:19 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 30026		
Estimate Number	: 12595		
P.O. Number	: N/A	Part Number	: D31881M
This Issue	: 12/20/2006 S.O. No. : N/A	Drawing Number	: D3188 REV BC LE 07.01.18
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: BC LE 07.01.18
Previous Run	: 30025	Material	: N/A
Written By	: <u>HA 061220</u>	Due Date	: 2/5/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>HA 061220</u>		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8 D2213 Spacer Batch: B25325 C207/02/02 (B)

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: 2767 C206/12/21  
 Description: D3188-1 BODY  
 Ship: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AP Date: 07/04/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:19 PM  
Ser: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 30026

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

*ml 07/03/08*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/03/08*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*①*  
*07/04/16*

Job Completion



*U of M. 16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	CE	HAMKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	REV. C
DATE 06.12.13	TITLE SPACEPOD BODY	SHEET 1 OF 11
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS

**GENERAL NOTES:**

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

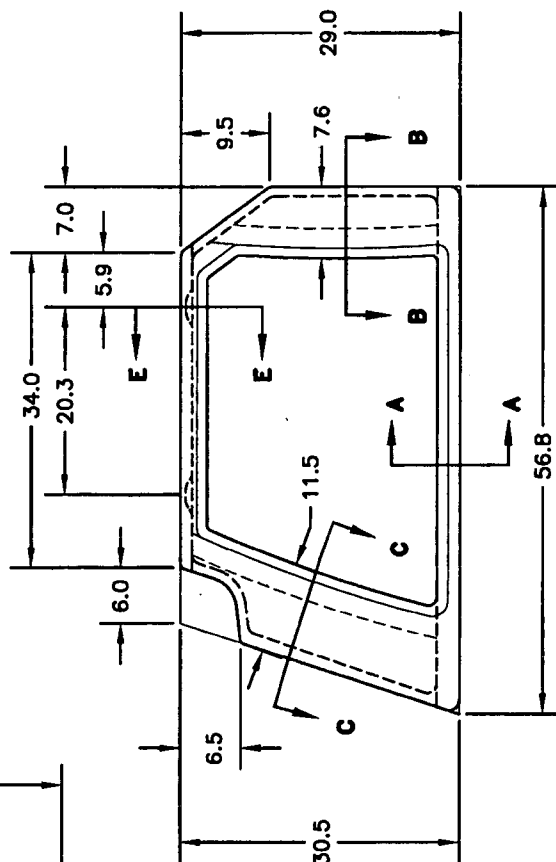
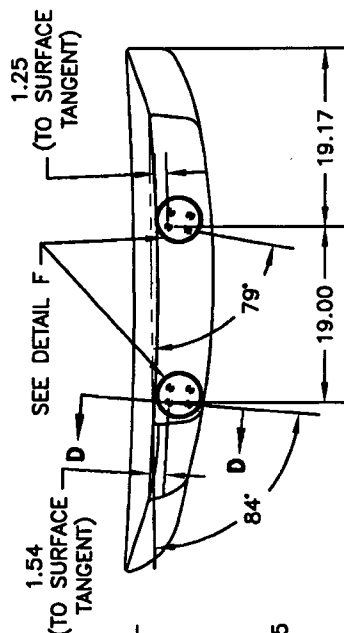
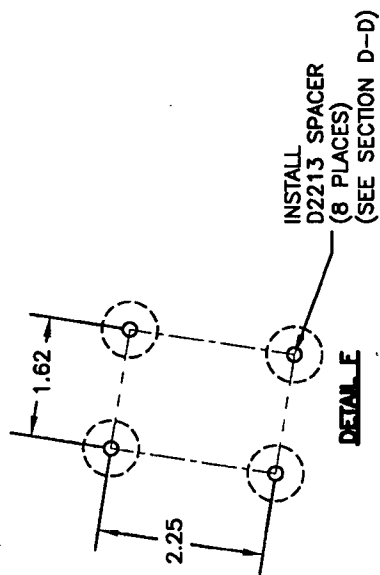
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06.12.22

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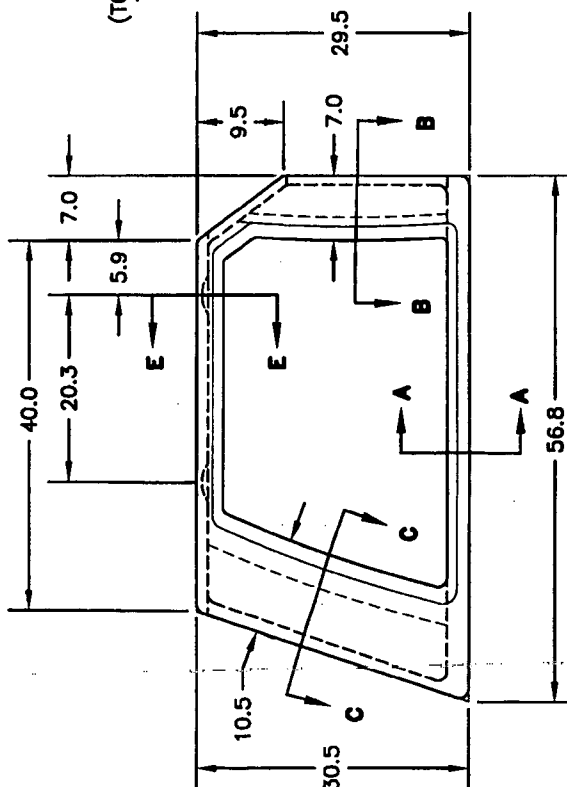
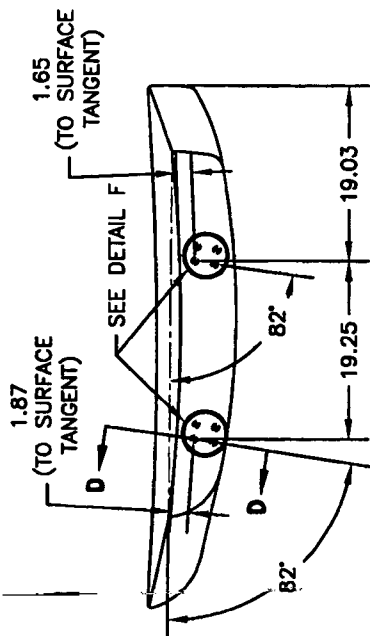
WORK ORDER  
30026UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT



DESIGN <b>JB</b>	DRAWN BY <b>LE</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. C SHEET 2 OF 11
DATE <b>06.12.13</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. 30026

RELEASED  
06-12-2013

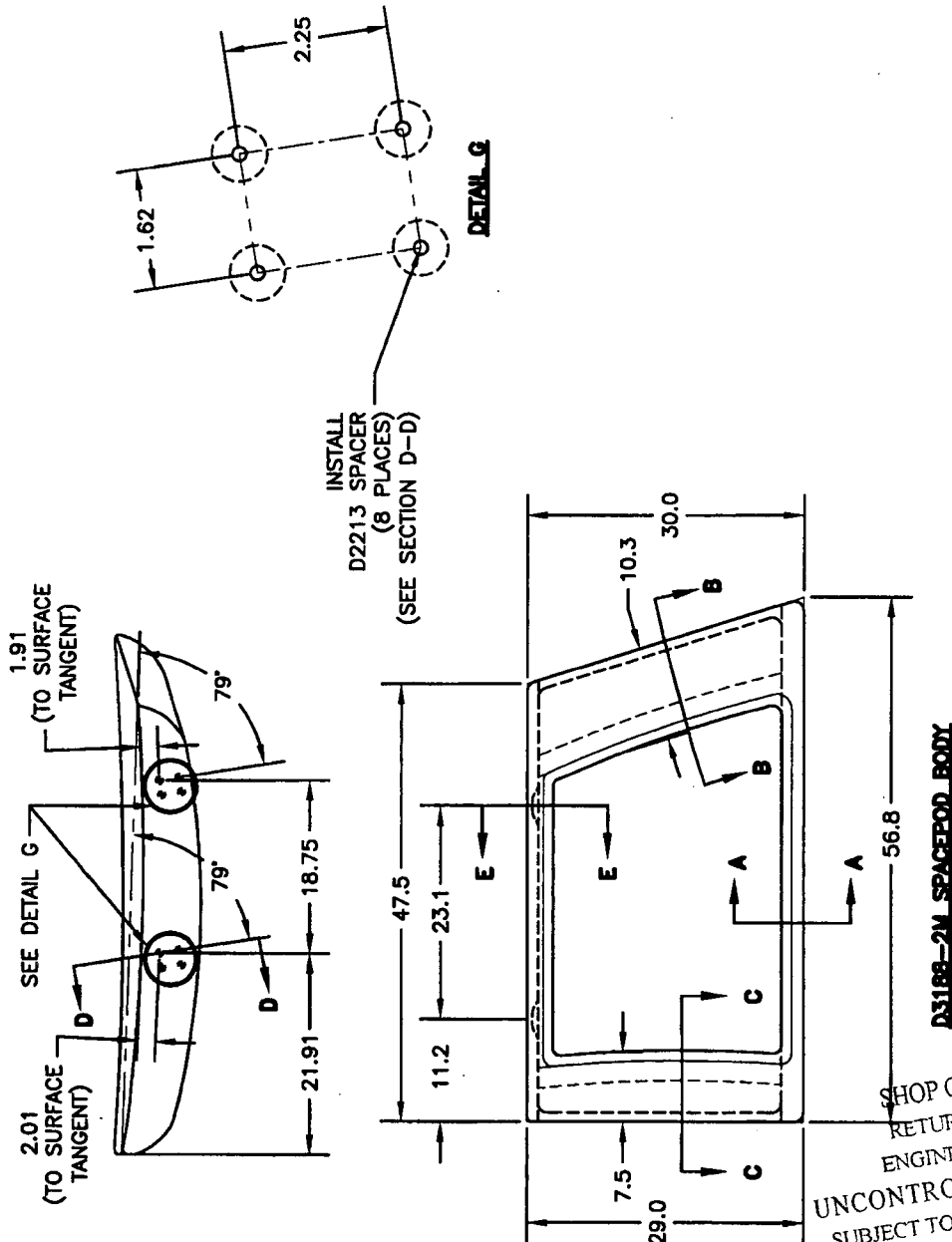
SEE SHEET #4 FOR SECTION VIEWS

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DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. C SHEET 3 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



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UNCONTROLLED COPY  
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ae no. 227

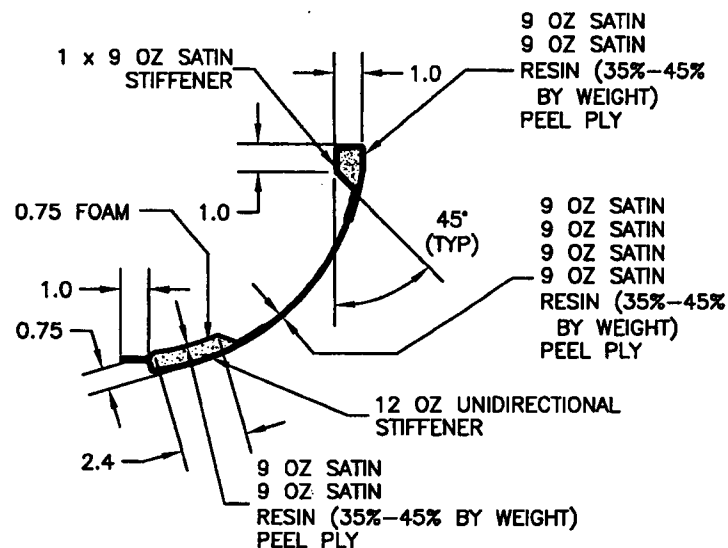
NOTE:  
SEE SHEET #4 FOR SECTION VIEWS

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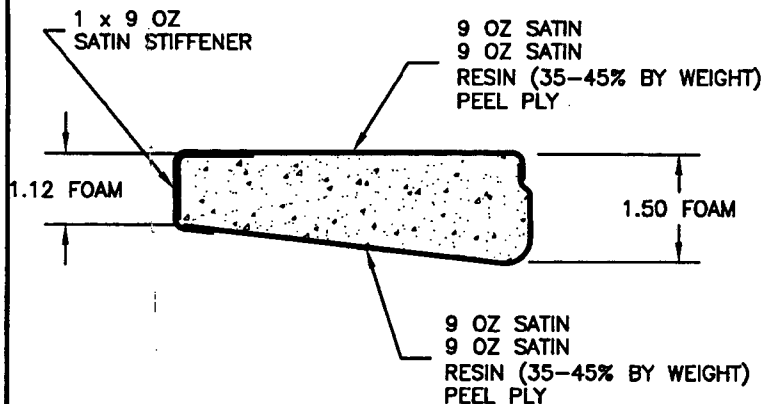
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**DART**

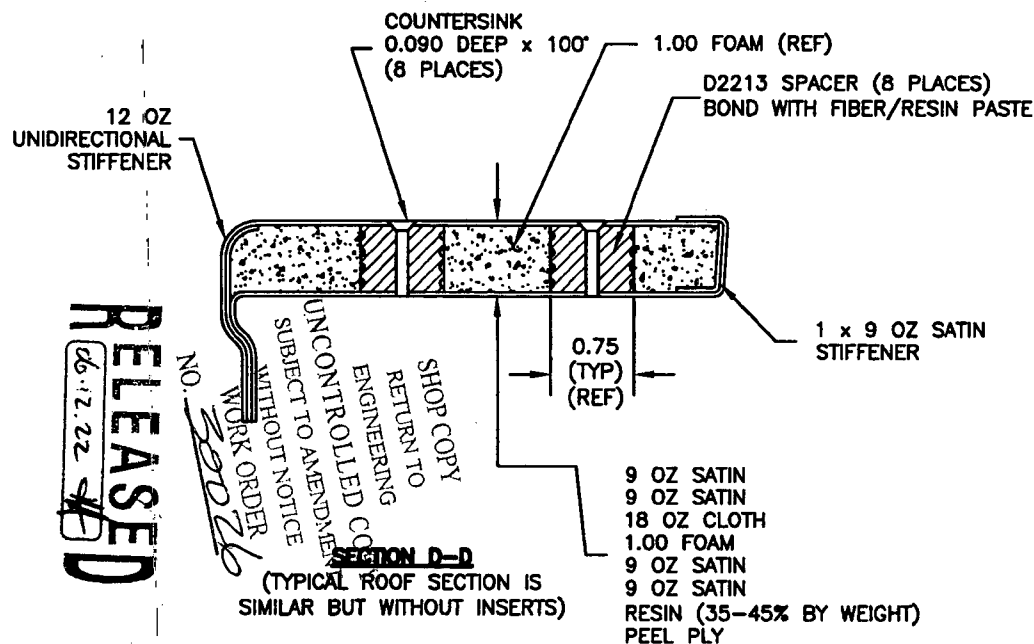
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CHECKED	04	APPROVED	11	HAWKESBURY, ONTARIO, CANADA
DATE	06.12.13	TITLE	D3188	REV. C
			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NIS



**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION E-E**  
(2 PLACES PER POD)

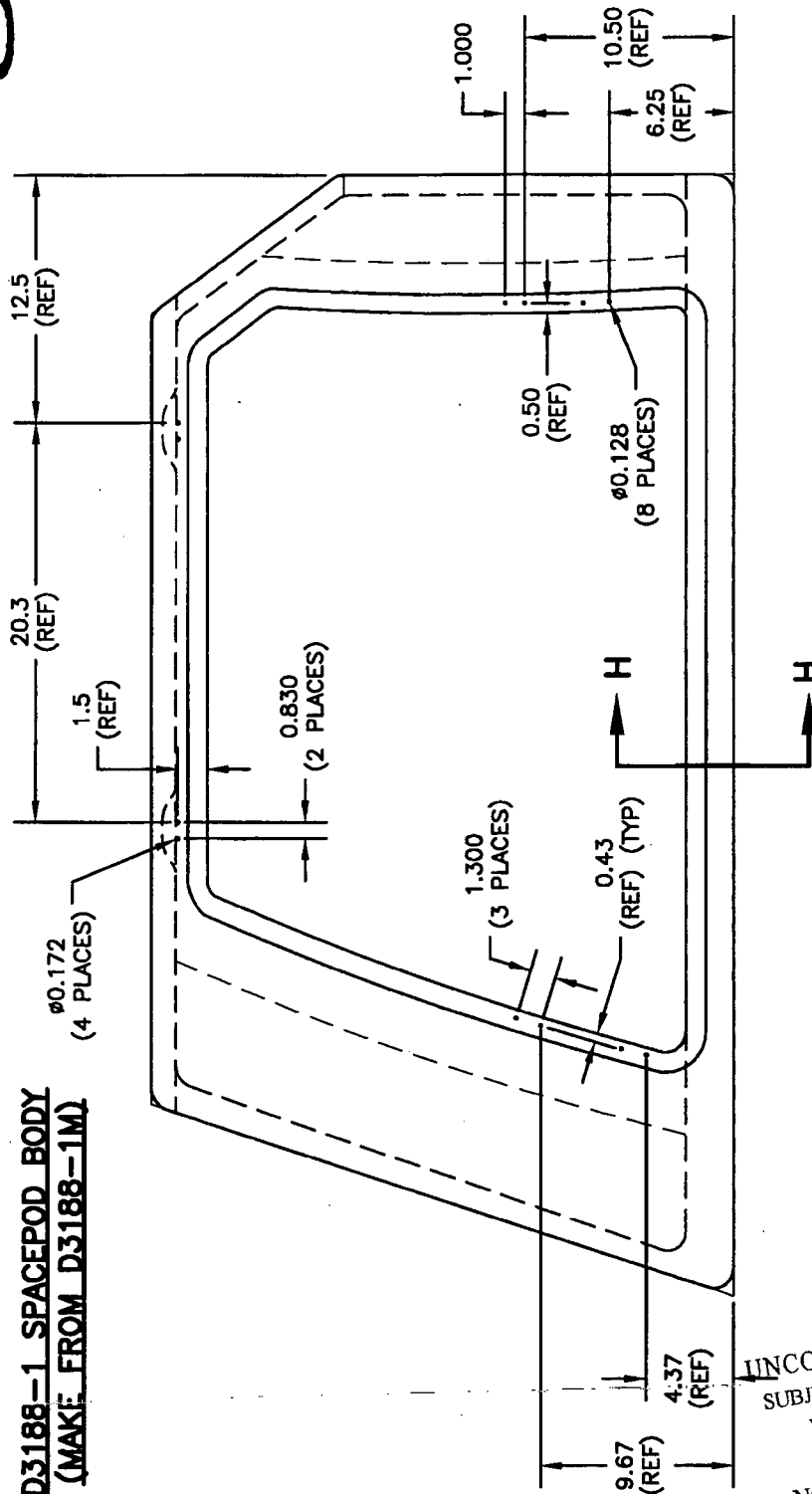
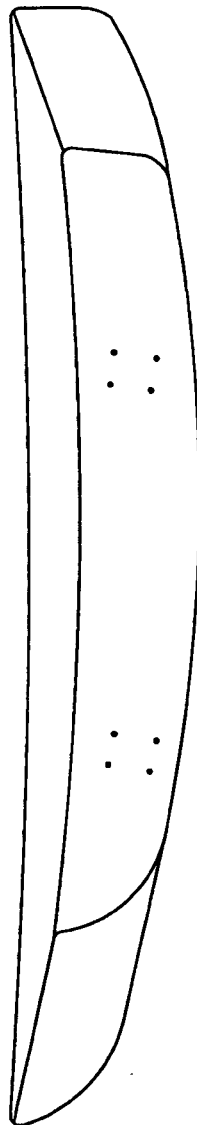
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

**D3188-1 SPACEPOD BODY**  
**(MAKE FROM D3188-1M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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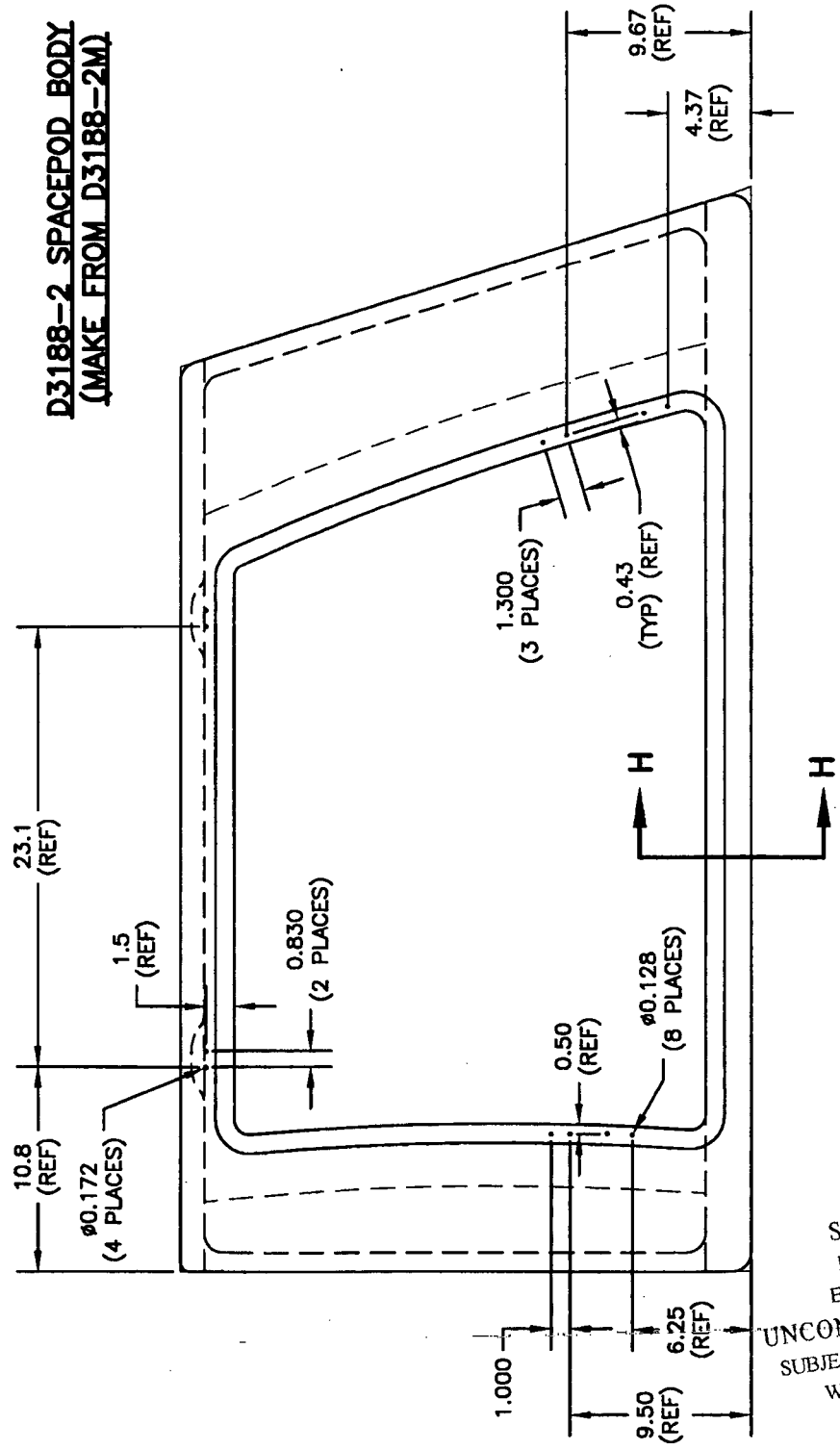
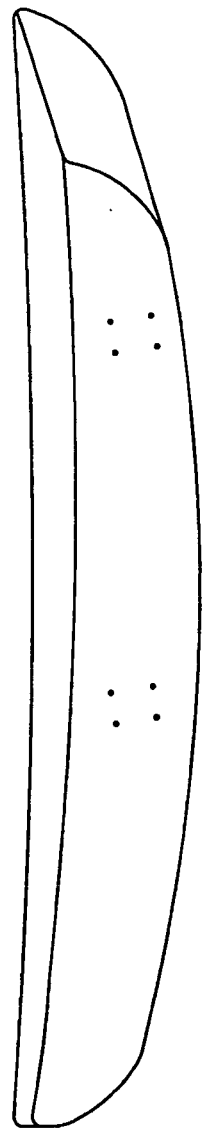




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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22 [Signature]

D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)



NOTES:  
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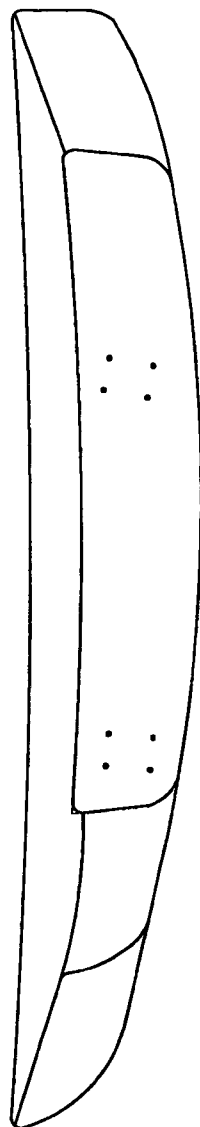
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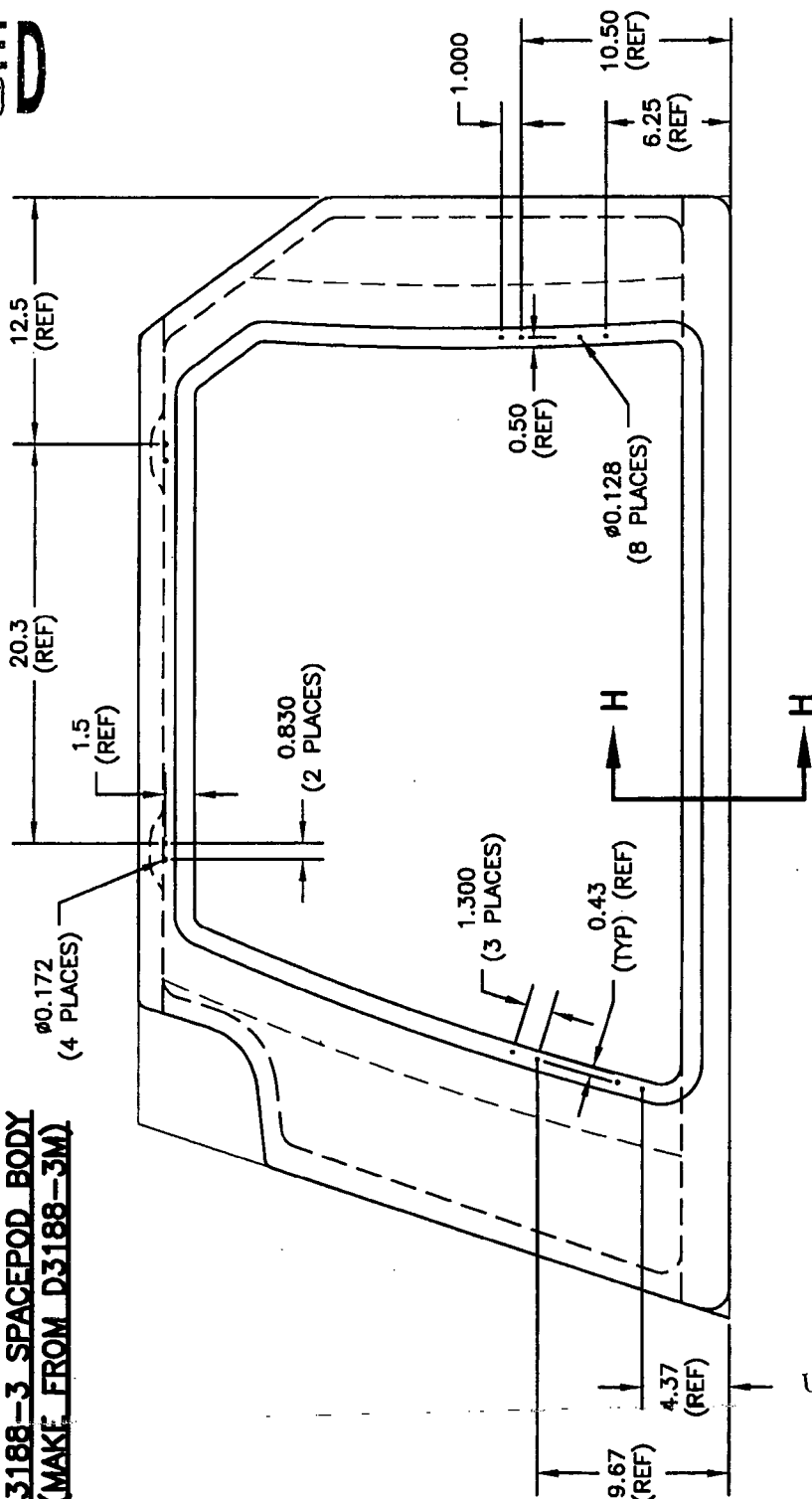


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
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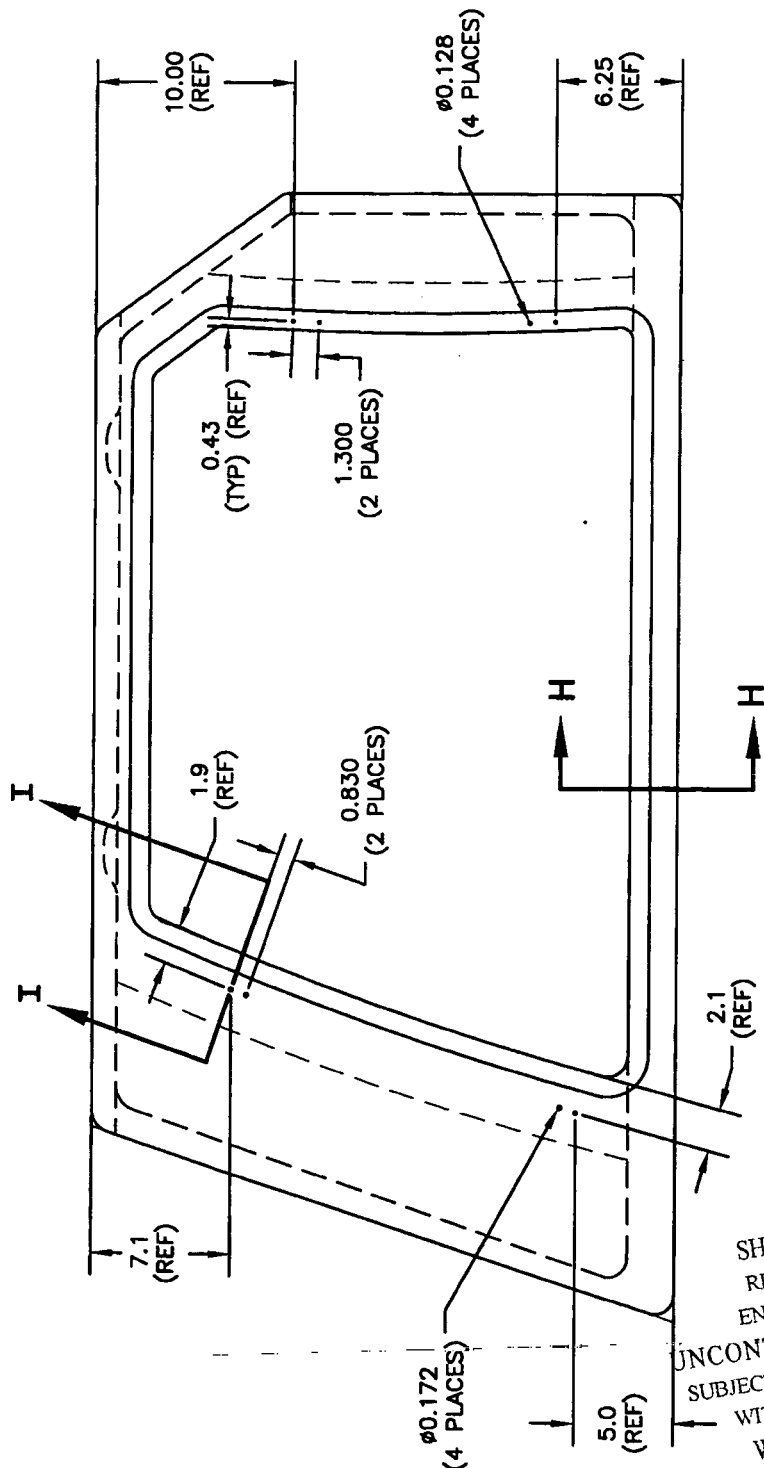
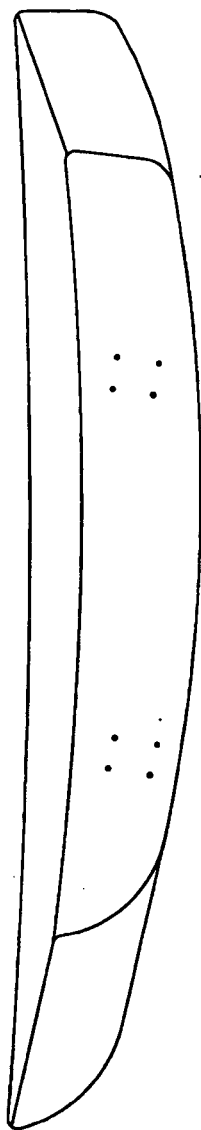
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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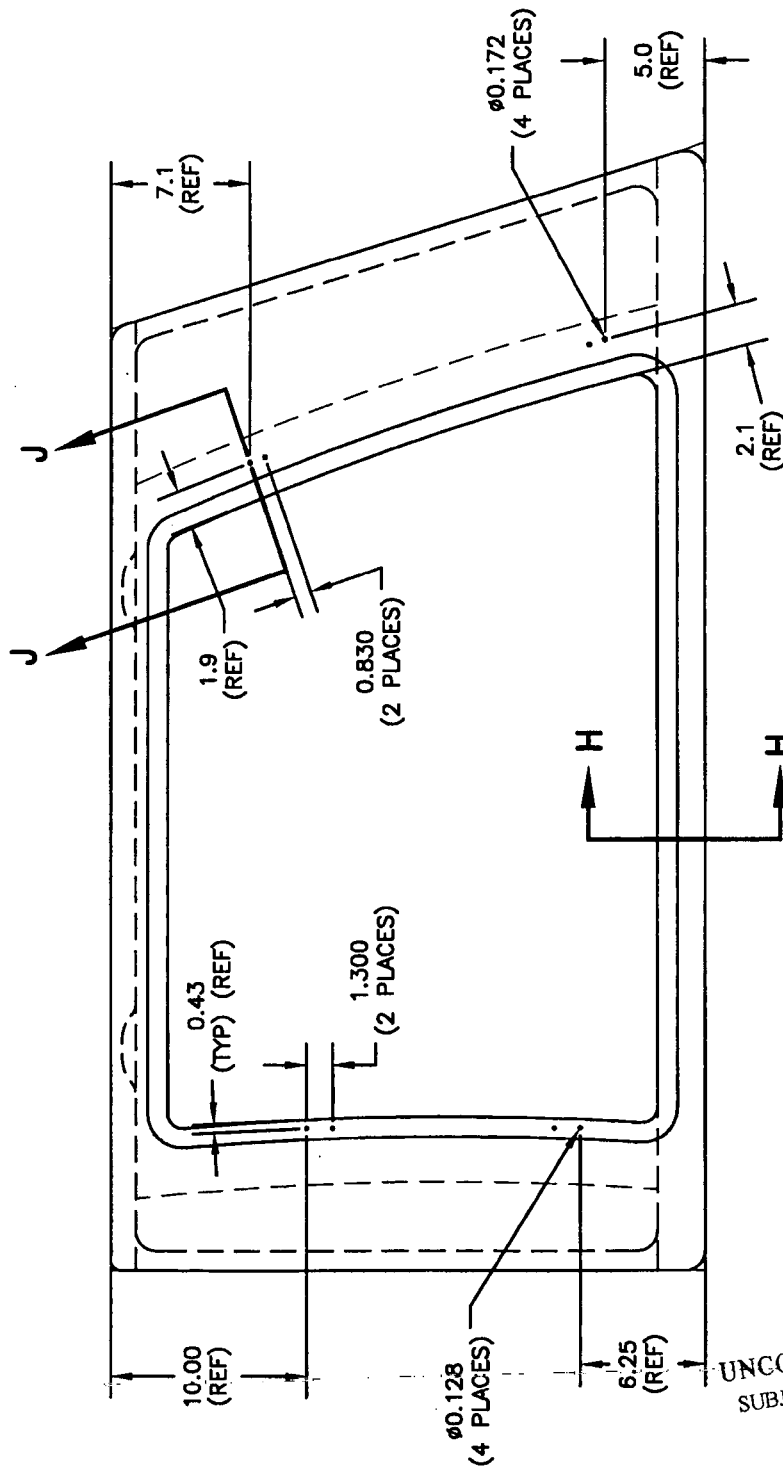
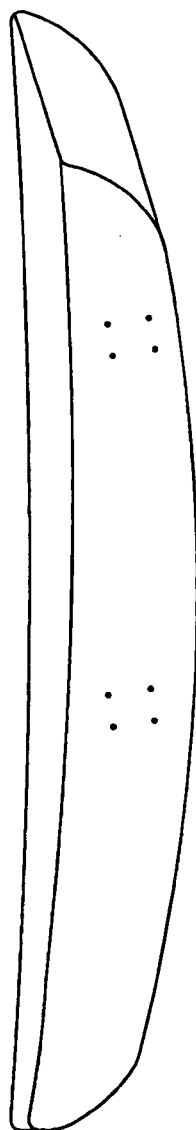
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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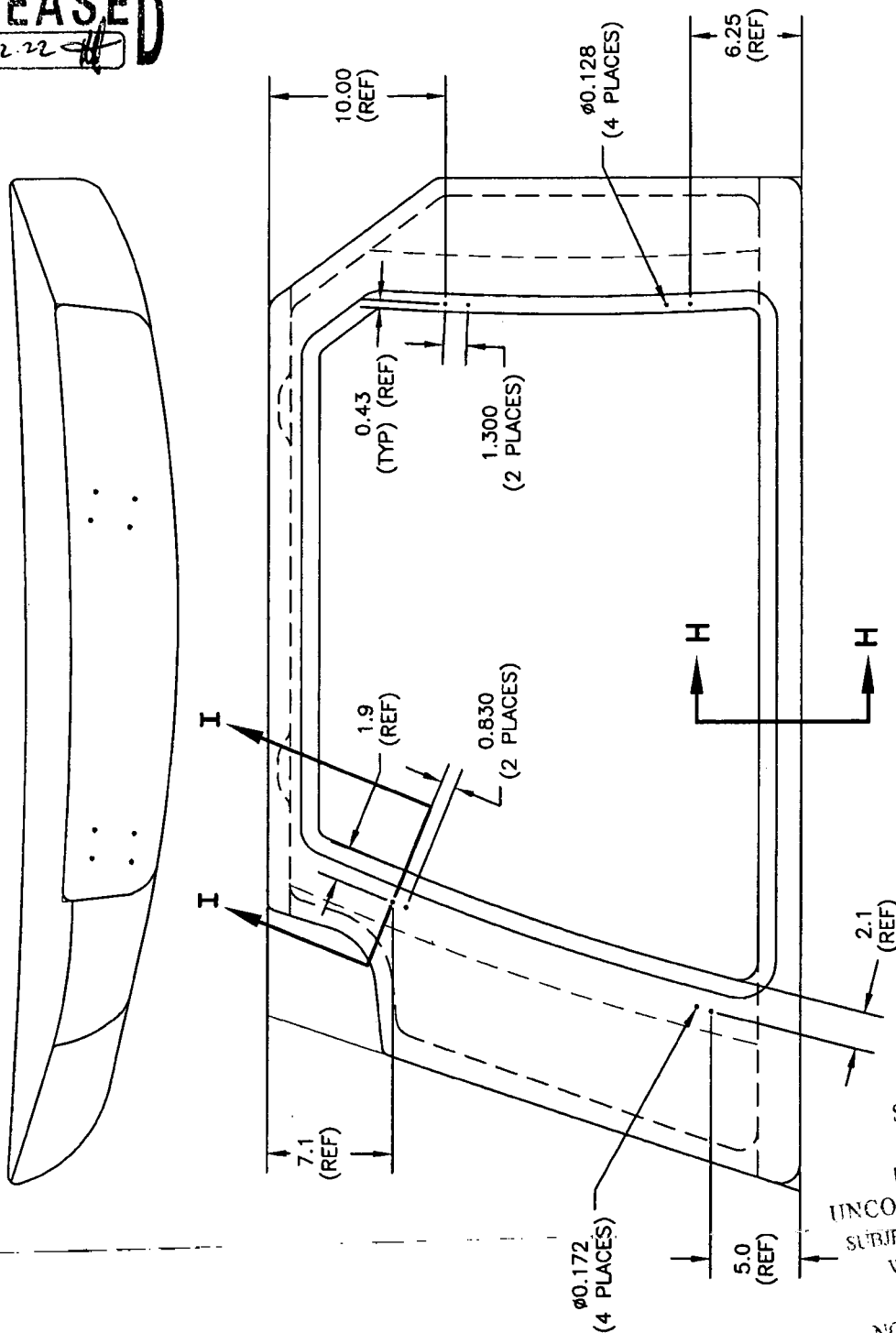
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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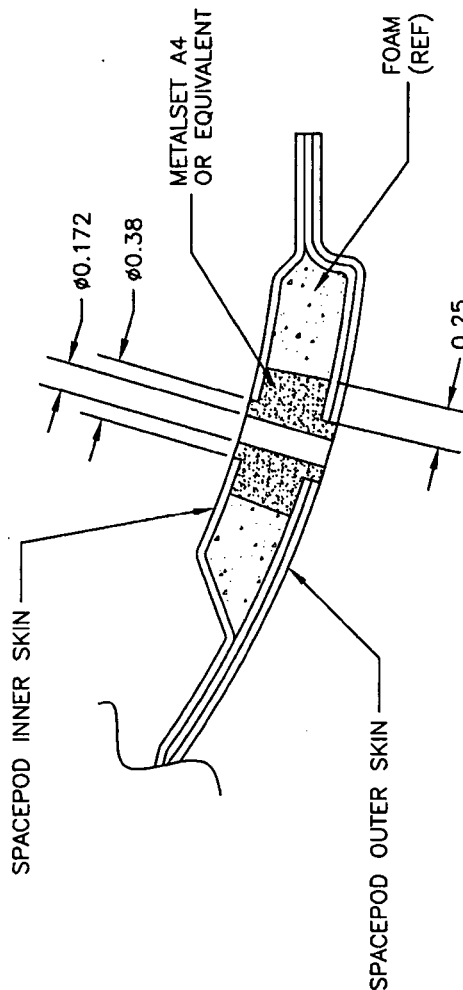
RELEASED  
06.12.22

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



SECTION H-H  
(TYPICAL FLOOR SECTION)



SECTION I-I  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Wednesday, 3/7/2007 4:32:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 31082B		
Estimate Number	: 12595		
P.O. Number	:	Part Number	: D31881M
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3188
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31081B	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>3/7/03.08</u>		
Comment	: Est Rev: A New issue ecn882 06-11-30 EC est rev B revc dwg 07.01.11 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8	D2213	Spacer	Batch: _____
---	-------	--------	--------------

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: \_\_\_\_\_  
 Description: D3188-1M BODY  
 Ship: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from.  
 Delastek is attached.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 3/7/2007 4:32:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 31082B

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART

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JB	CE	D3188
DATE	TITLE	REV. D
07.02.22	SPACEPOD BODY	SHEET 1 OF 11
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS

## GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART  
D3188-1M/-1/-5  
D3188-2M/-2/-6  
D3188-3M/-3/-7

LAYUP  
DT8003  
DT8004  
DT8500

TRIM AND DRILL  
DT8501  
DT8502  
DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

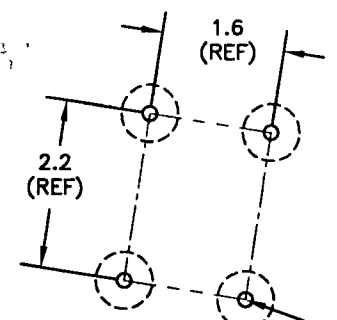
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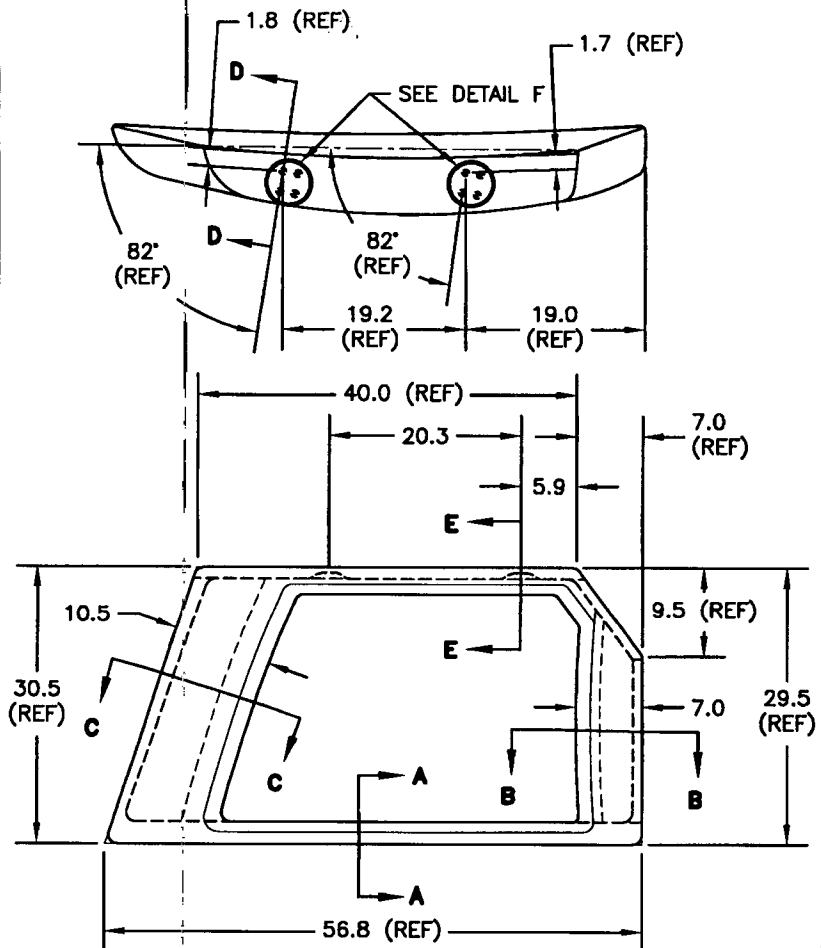
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TITLE	SPACEPOD BODY	SHEET 2 OF 11	REV. D	
SCALE	NTS			

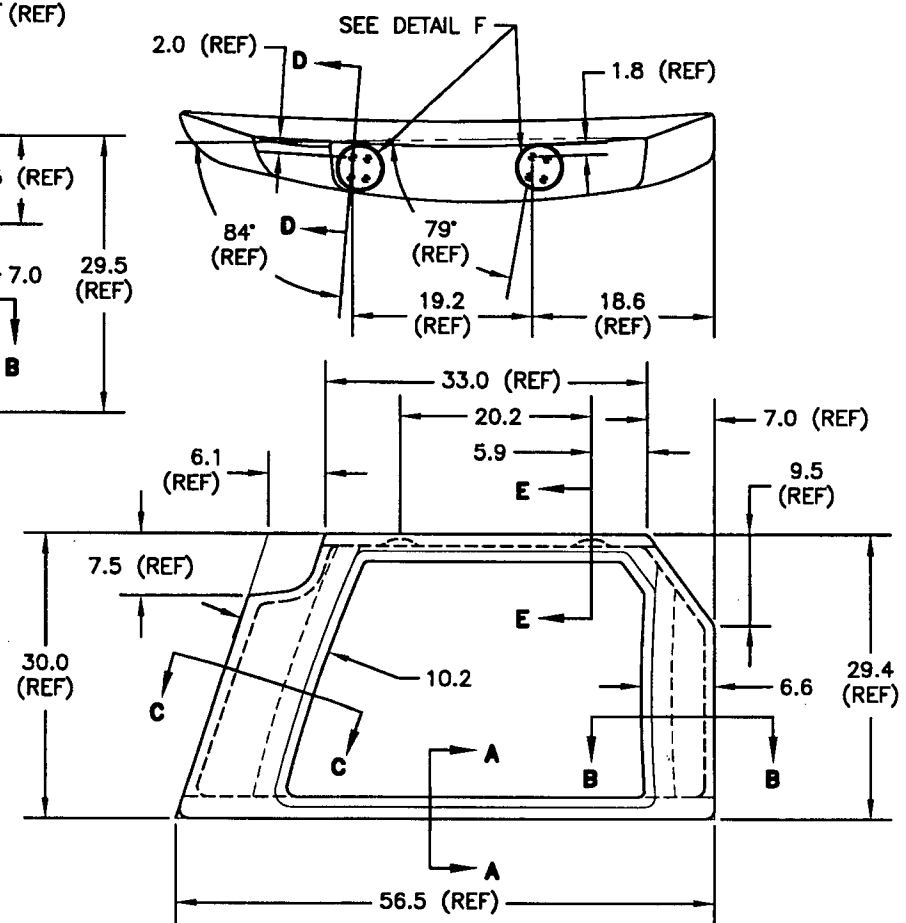


**DETAIL F**

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

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- D3186-1M/-3M NOTES:**
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  2. SEE SHEET #4 FOR SECTION VIEWS.

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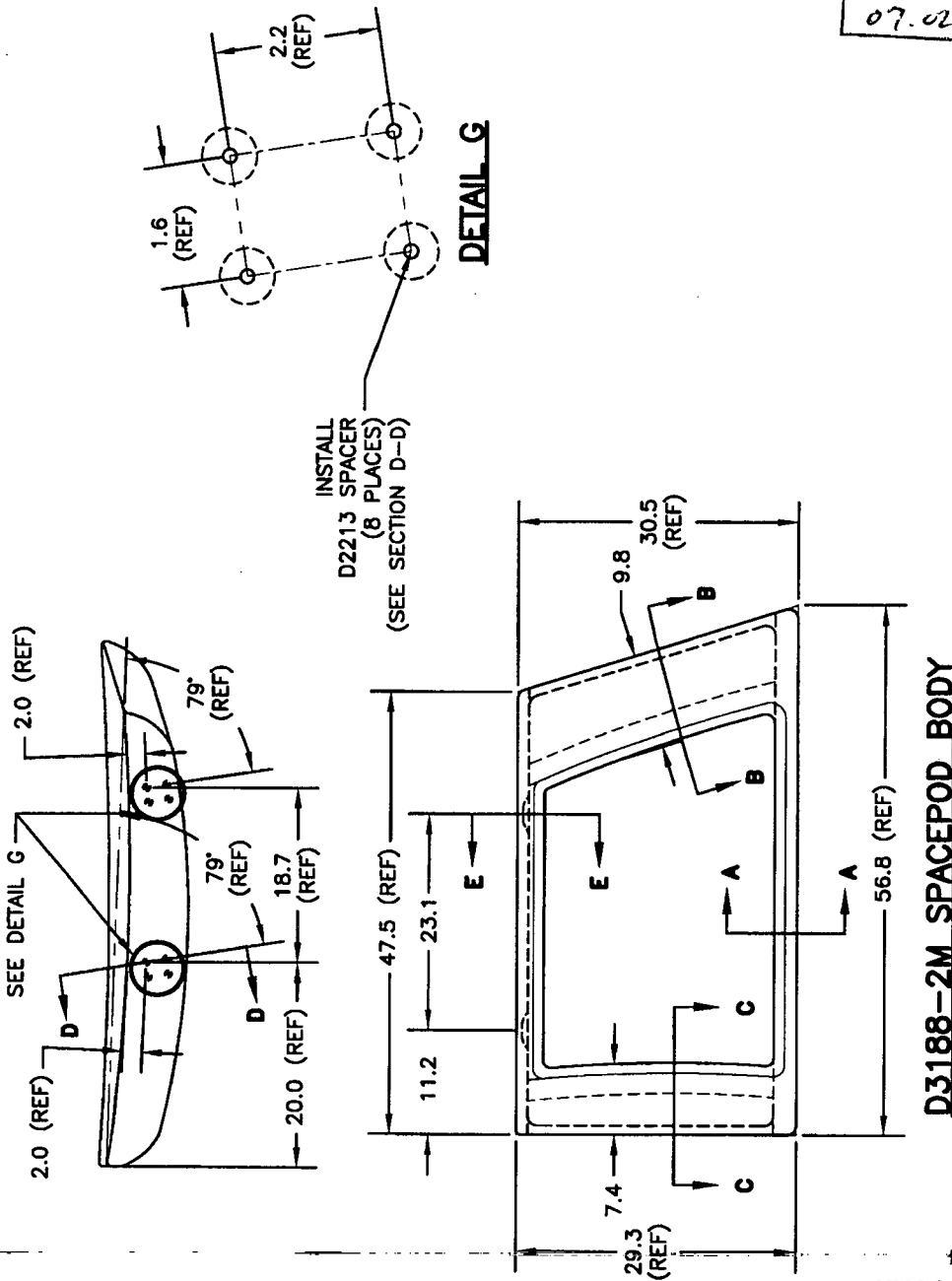
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NO. 31082B

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2. SEE SHEET #4 FOR SECTION VIEWS.

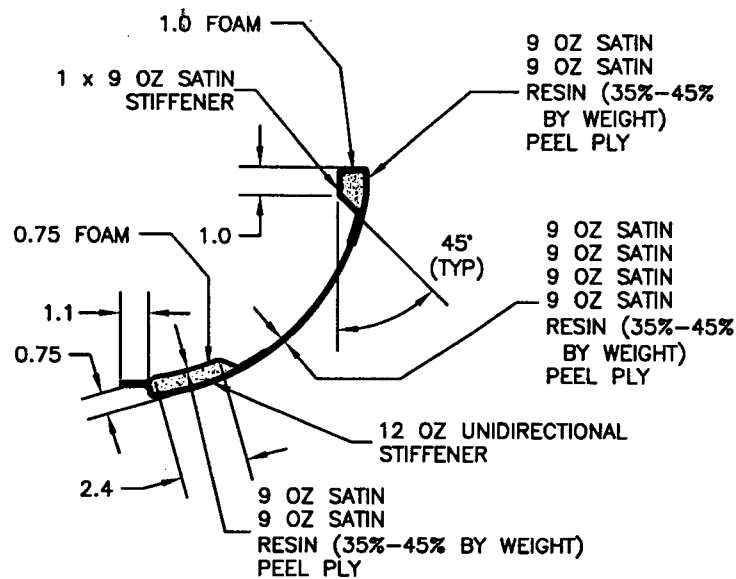
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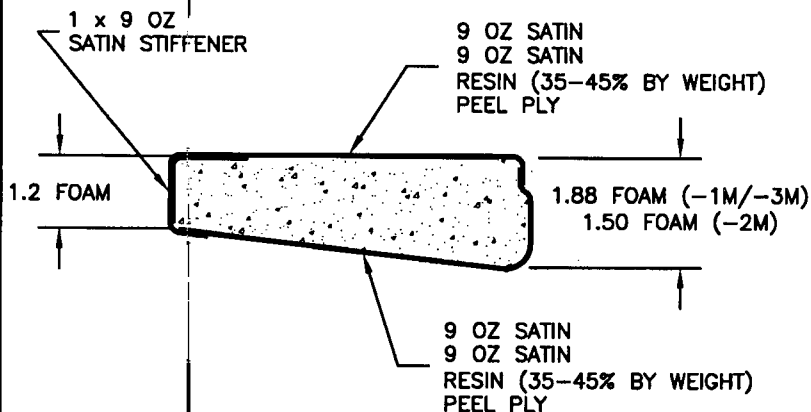
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

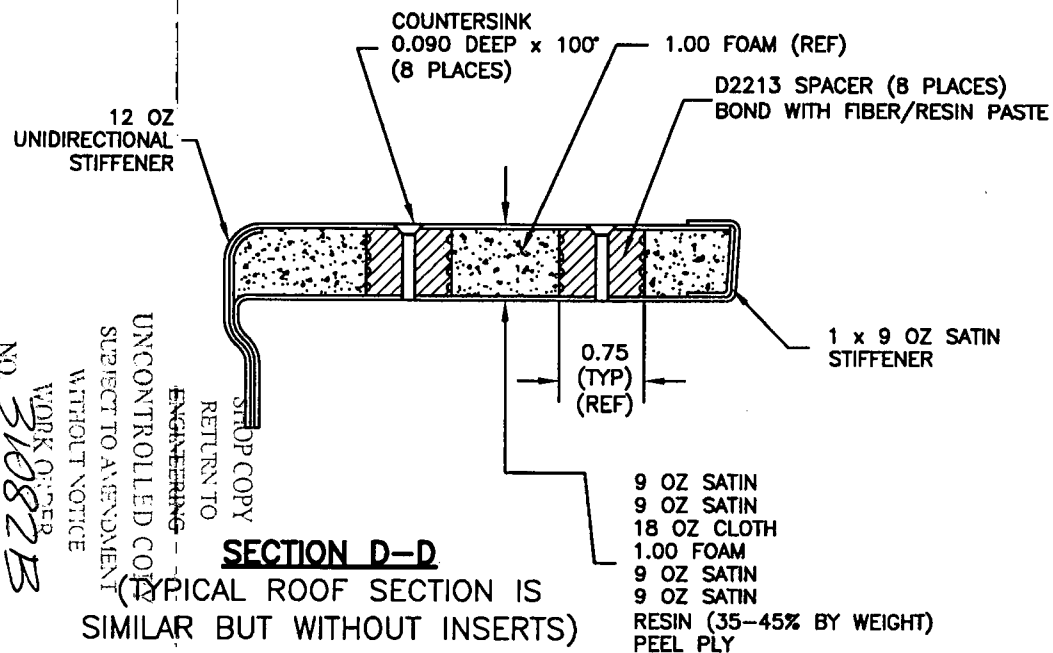
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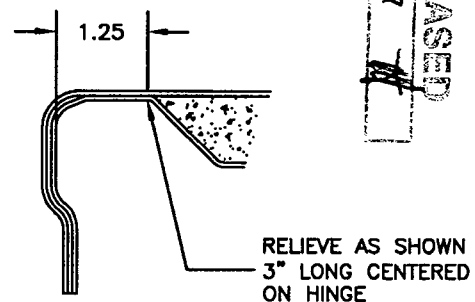
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

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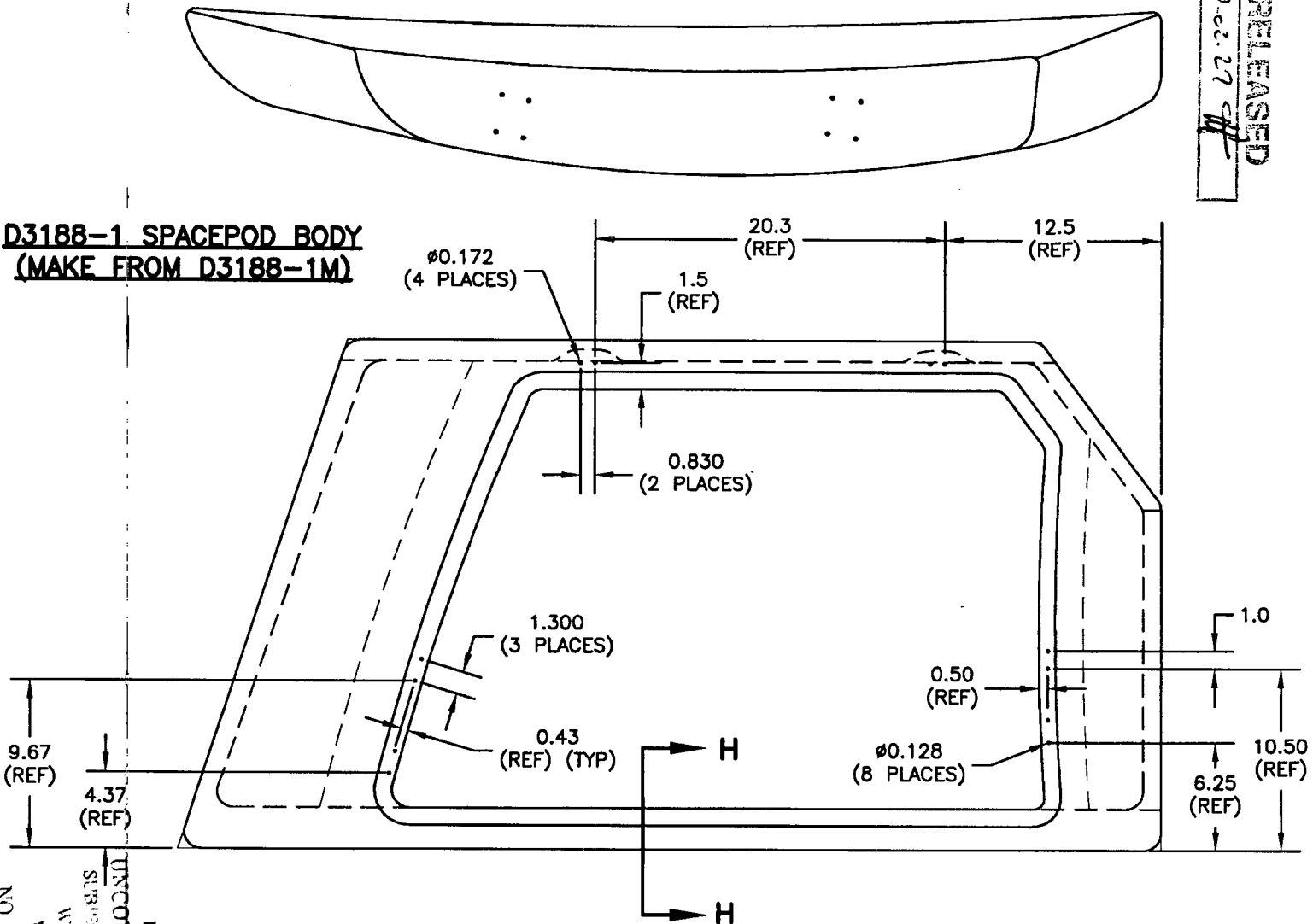
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DATE	07.02.22					SCALE
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07-02-22



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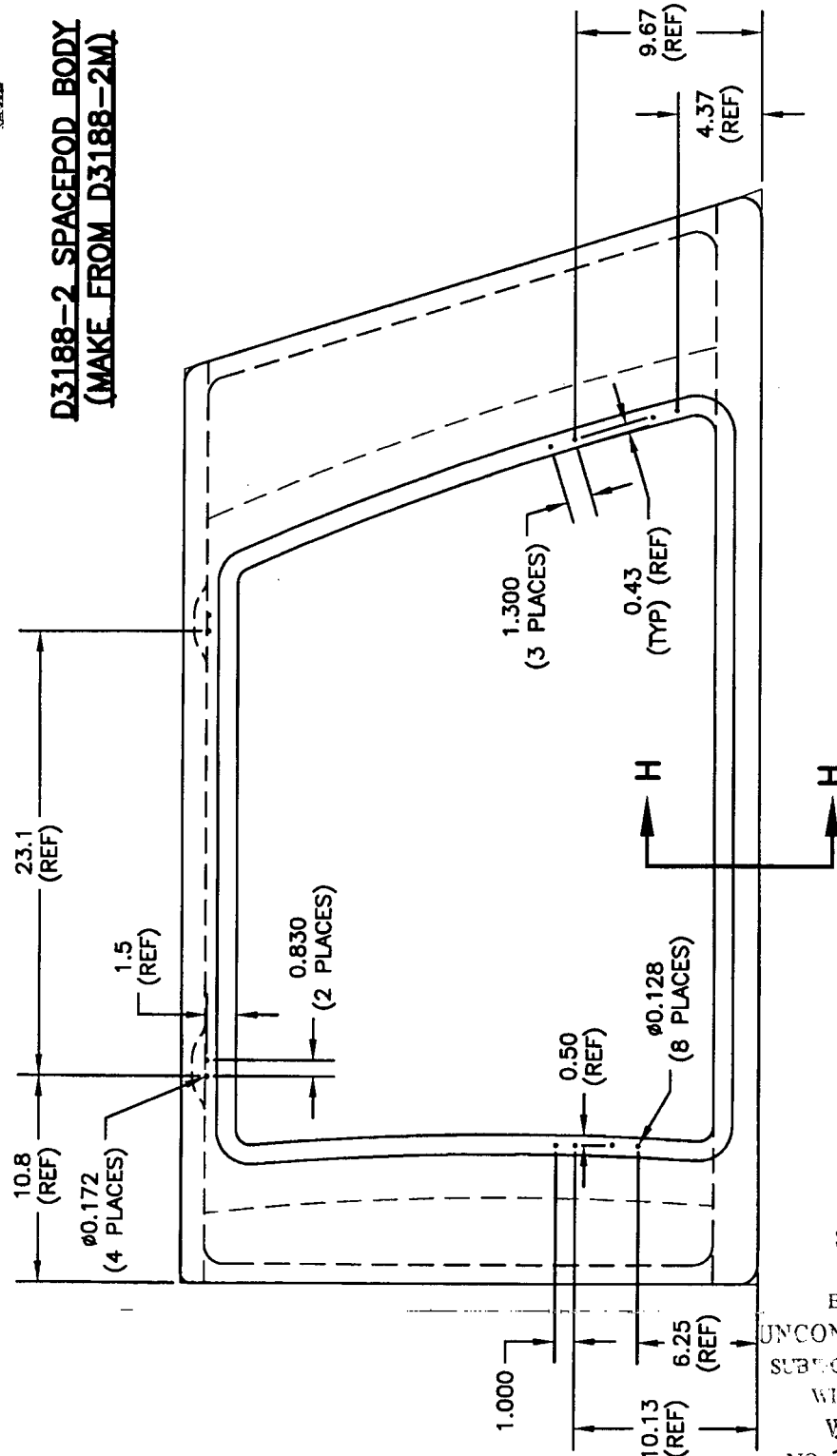
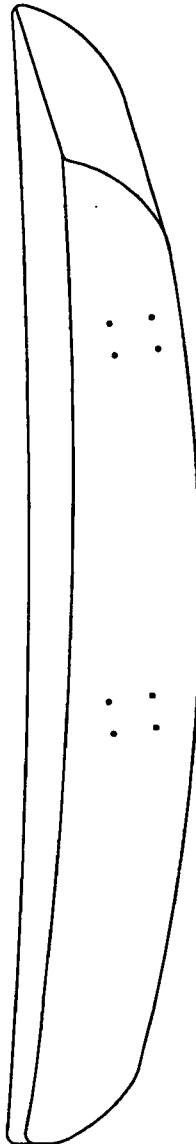
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**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
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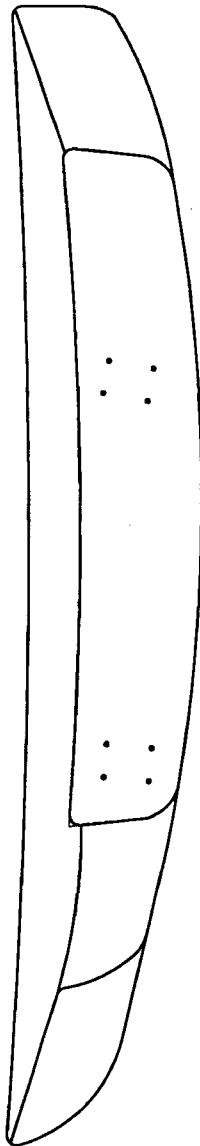


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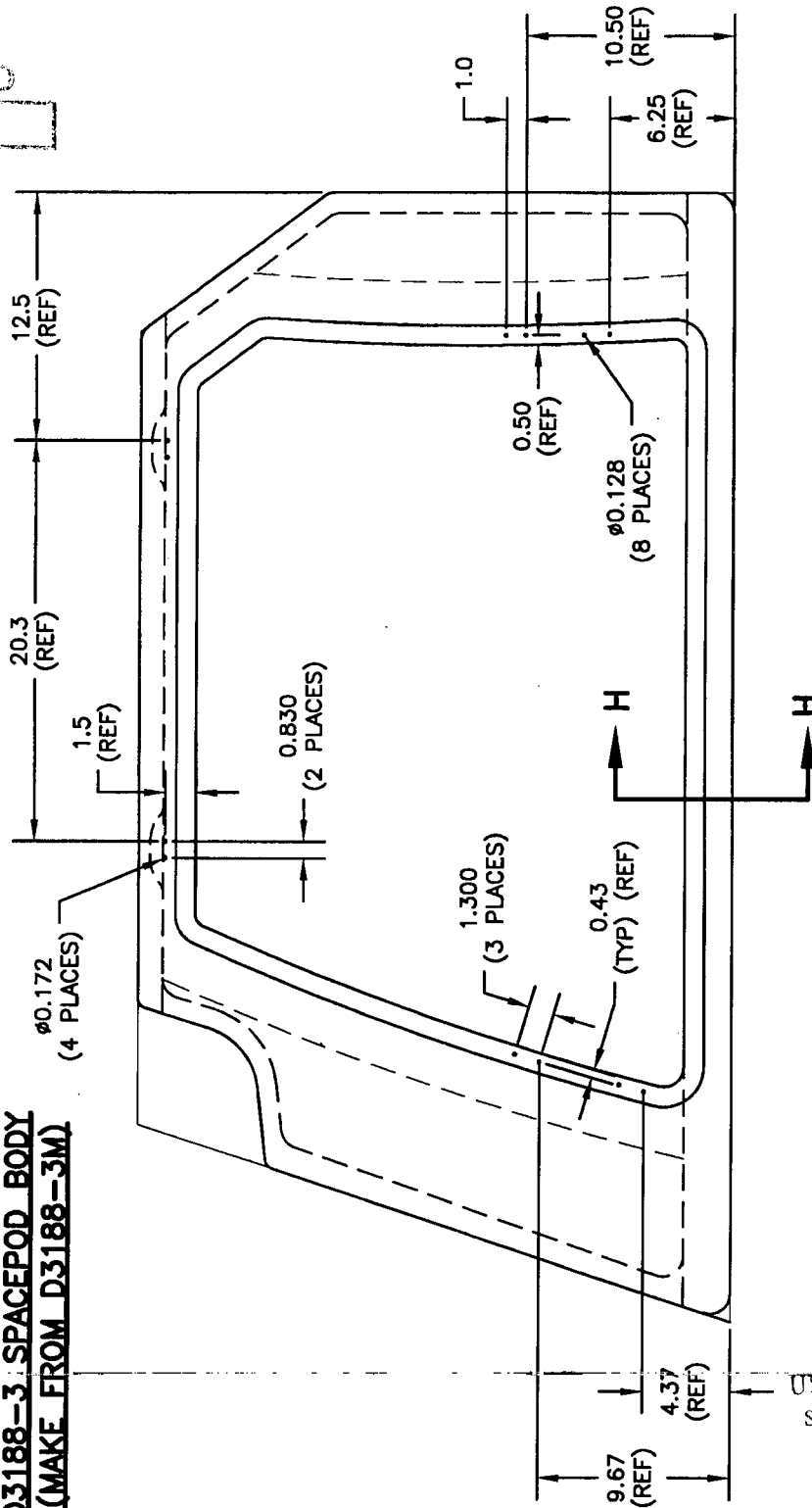
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**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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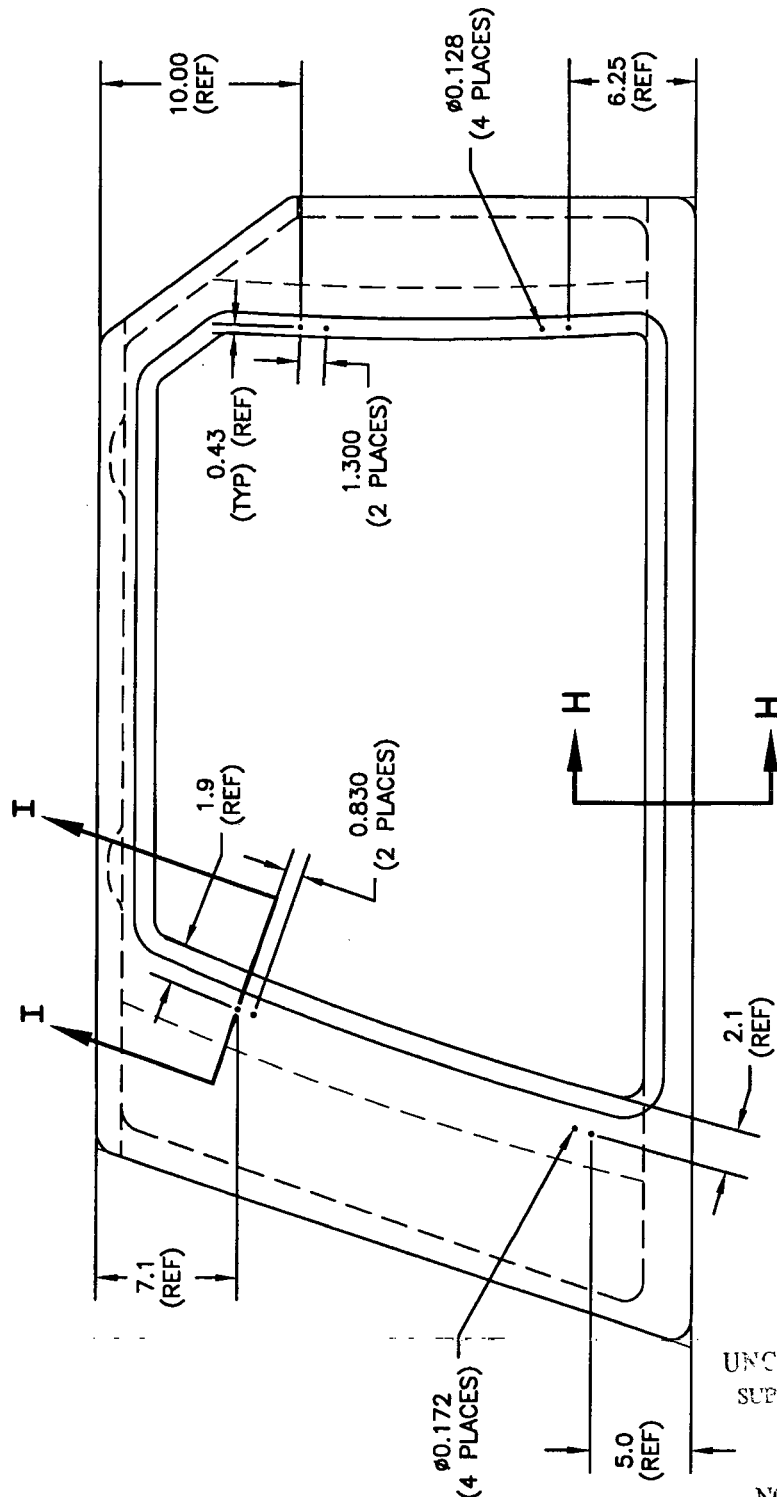
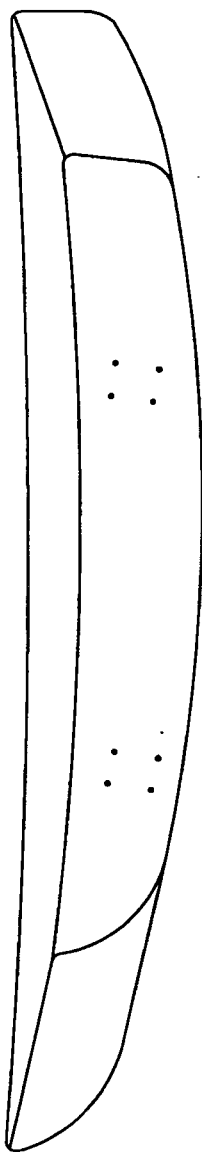
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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 8 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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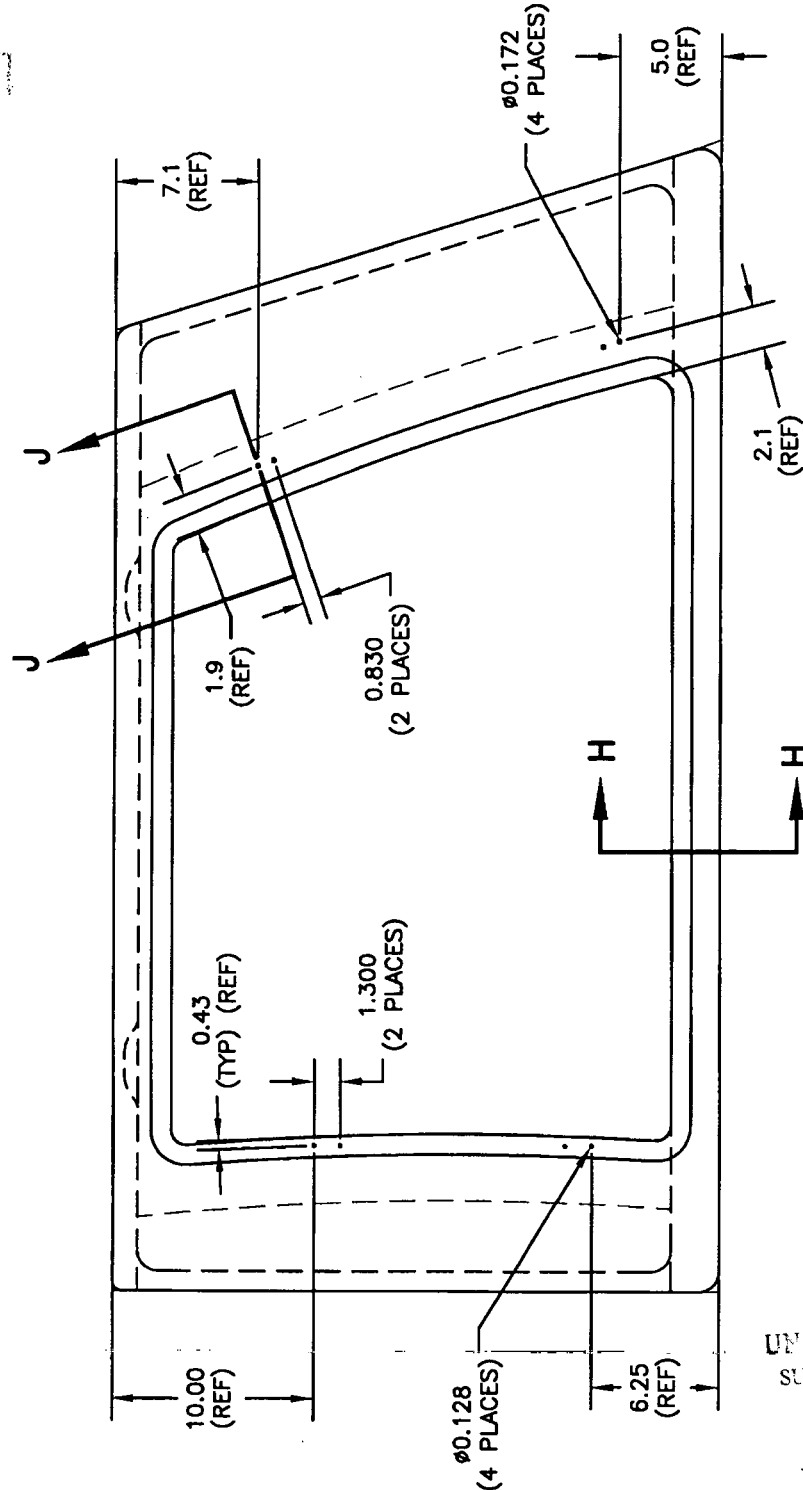
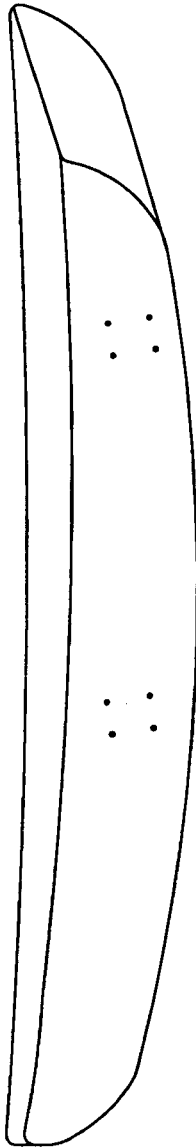
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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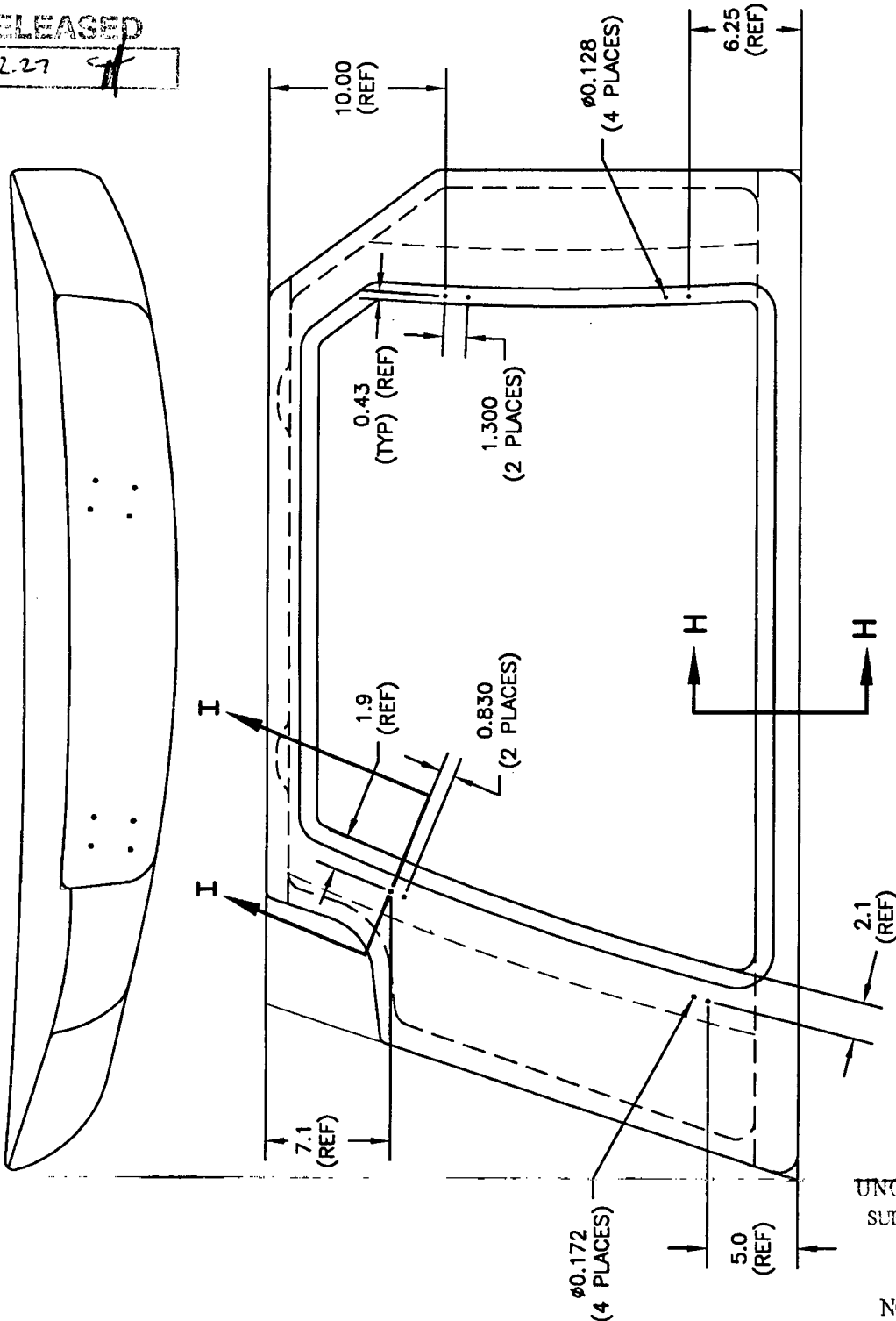
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.22

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

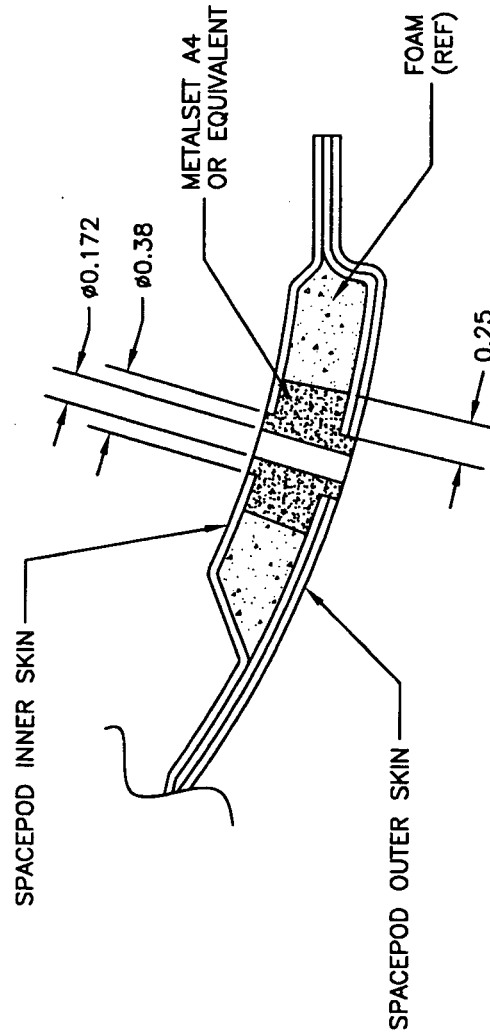
RELEASED

07.02.27

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)

**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Wednesday, 3/7/2007 4:32:05 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001, Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31082C01		
Estimate Number	: 12598		
P.O. Number	:	Part Number	: D31861M
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31081C01	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.08</u>		
Comment	: Est Rev A New Issue 06-12-04 ec Est-rev D rv D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of  
 doo is smooth, no dimples for drilling.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/7/2007 4:32:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 31082C01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

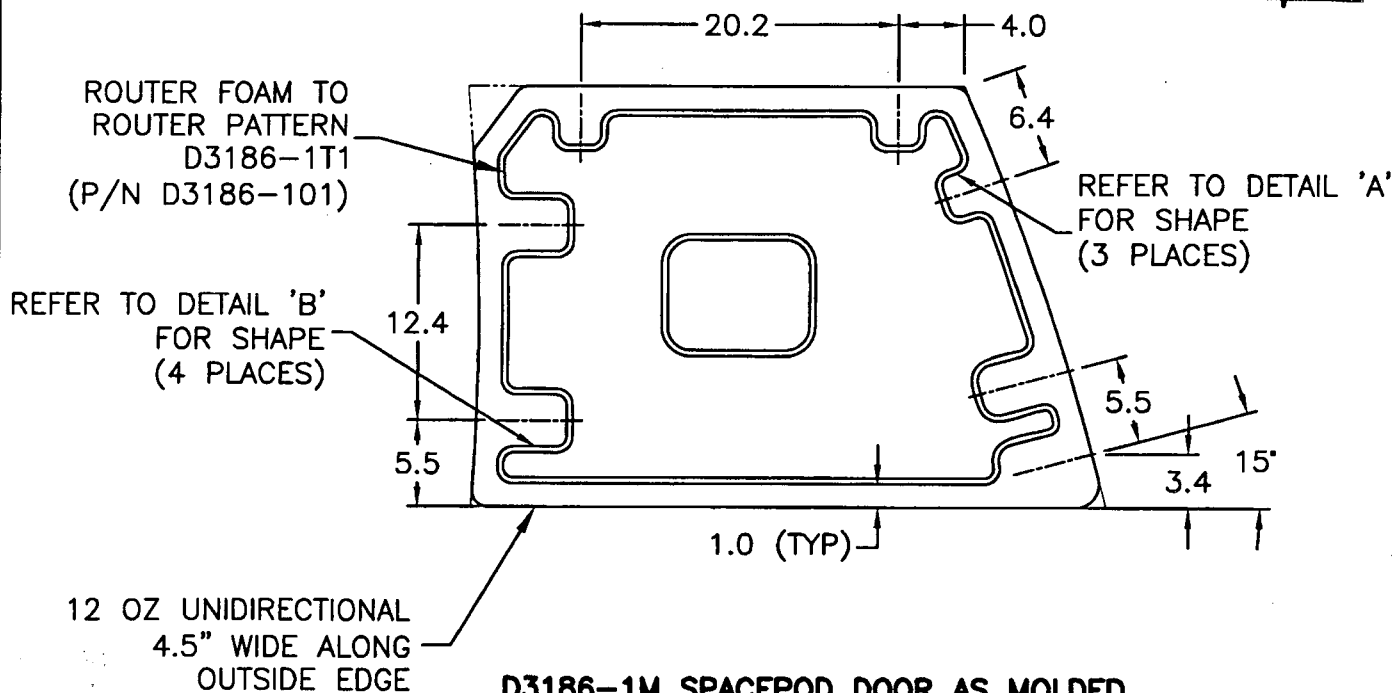
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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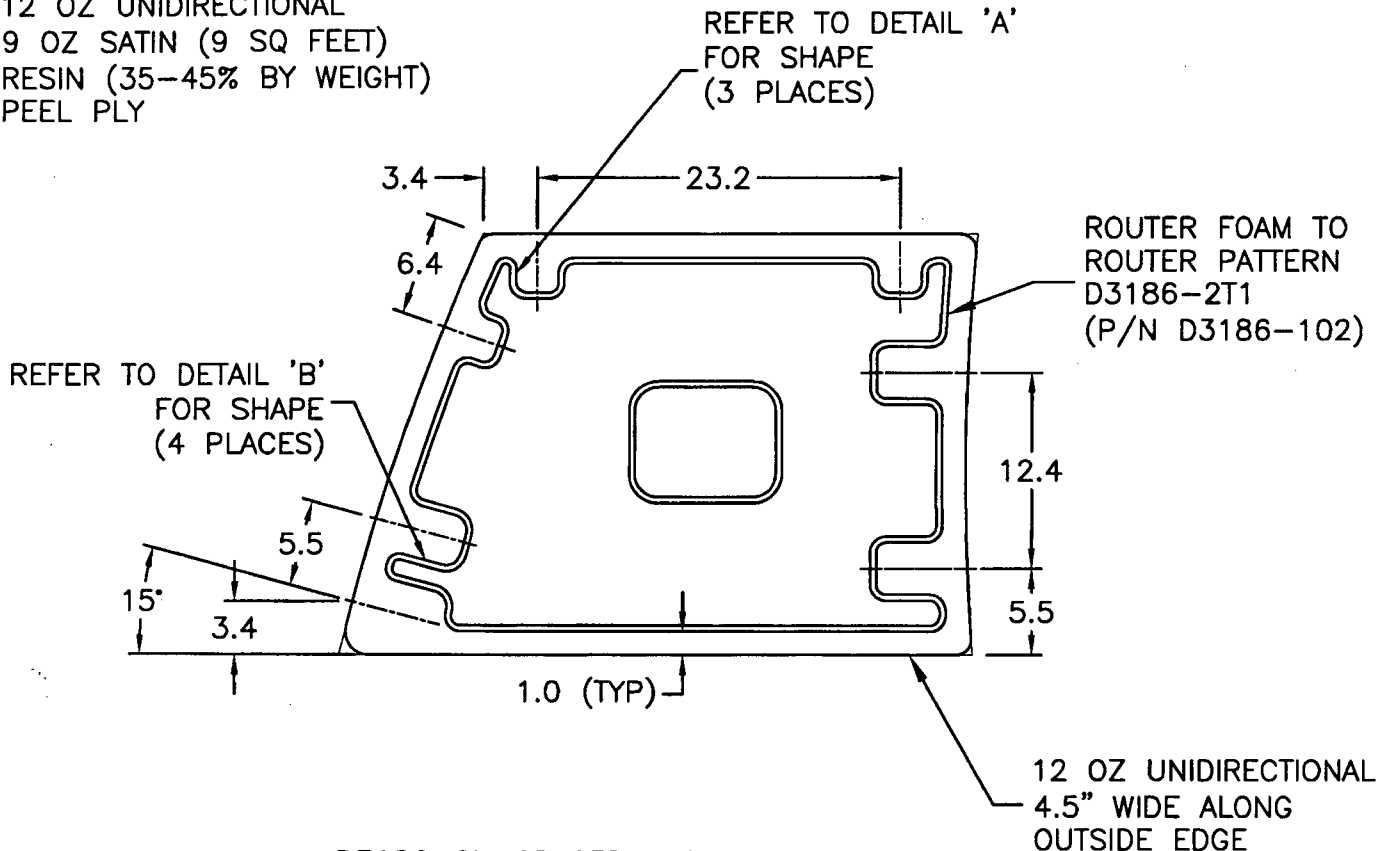
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D31P6-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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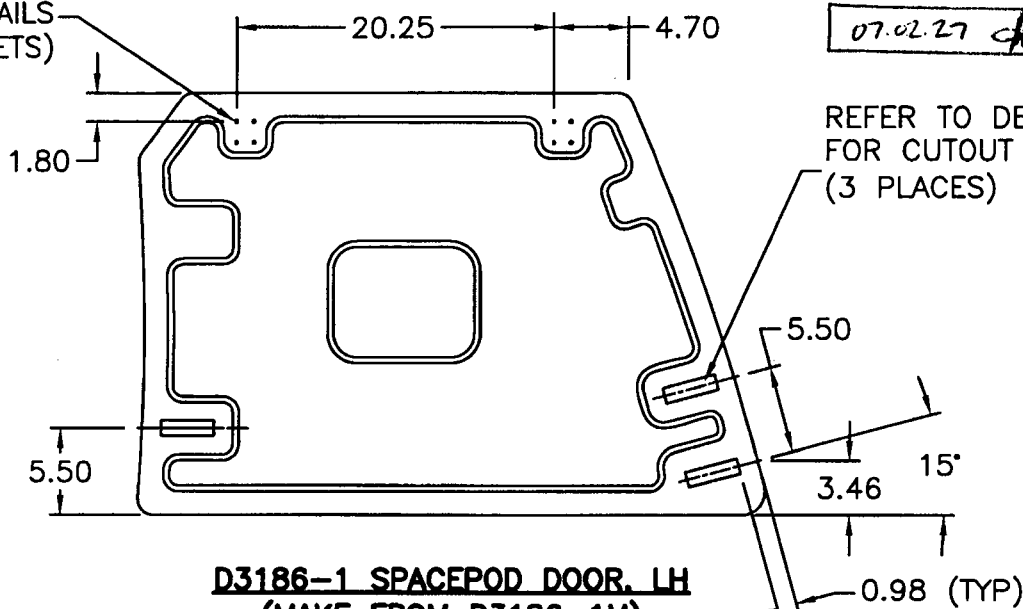
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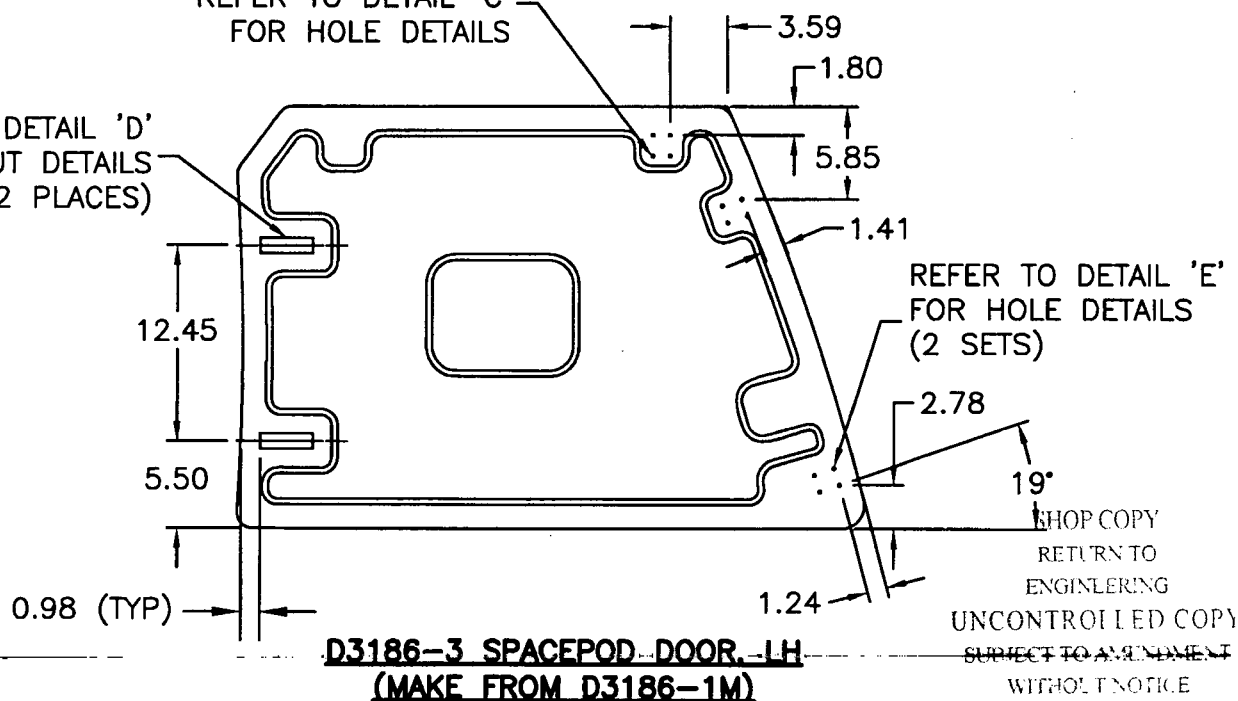
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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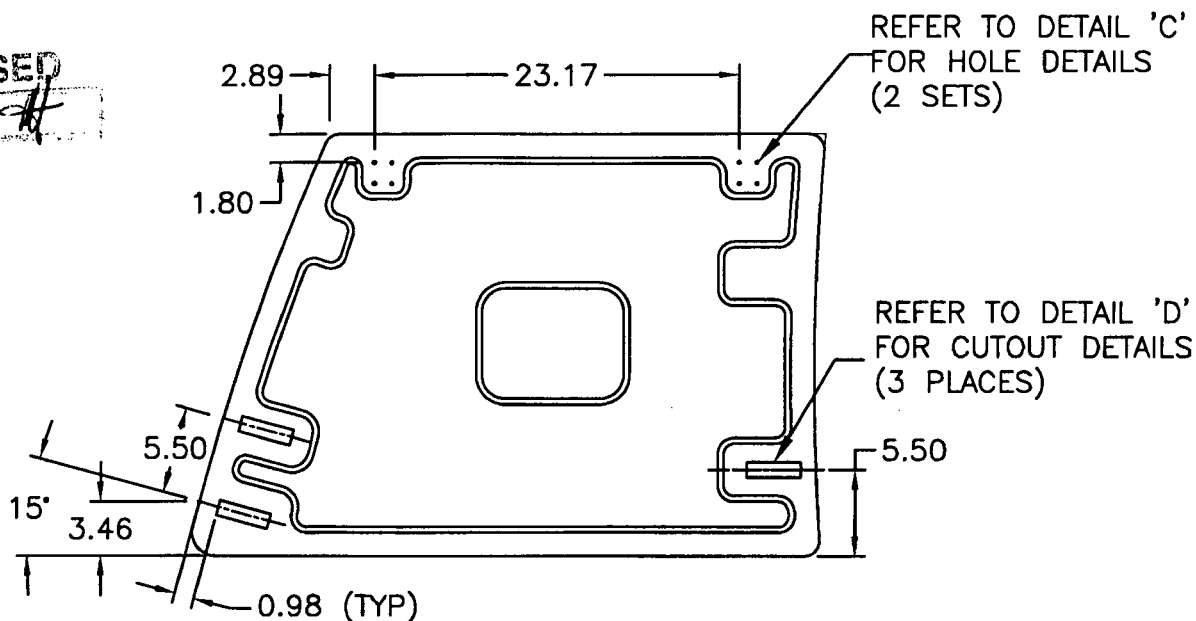
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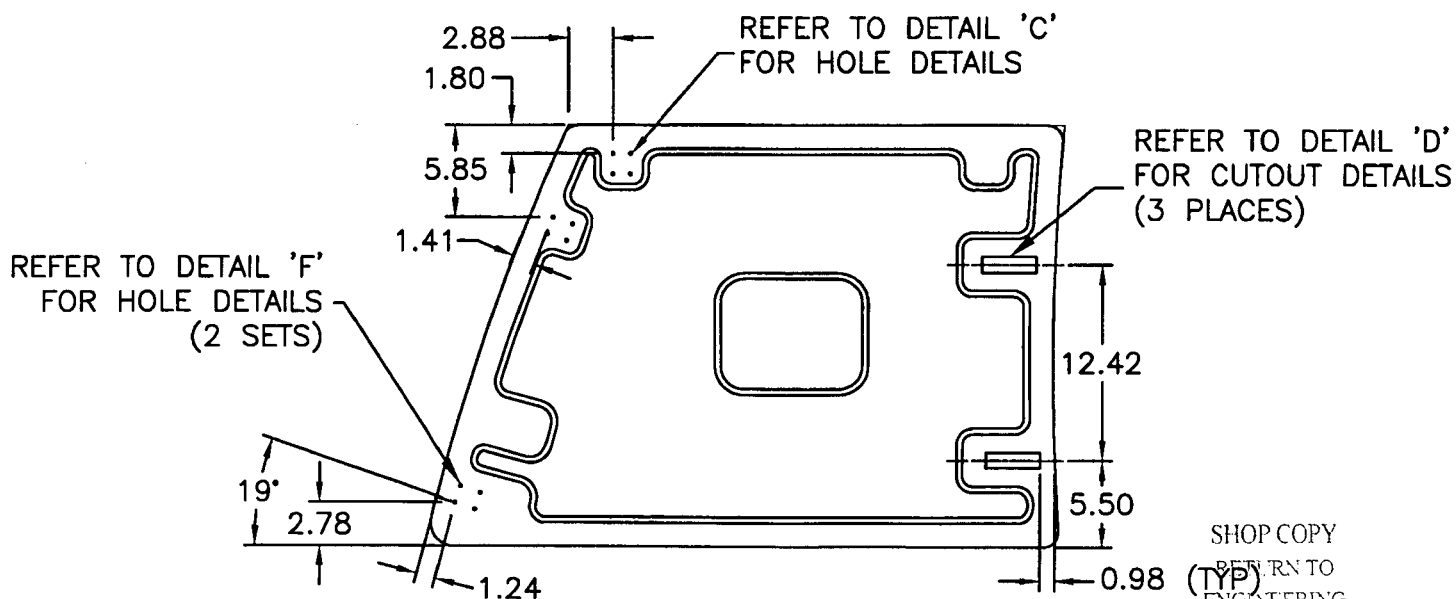


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED  
07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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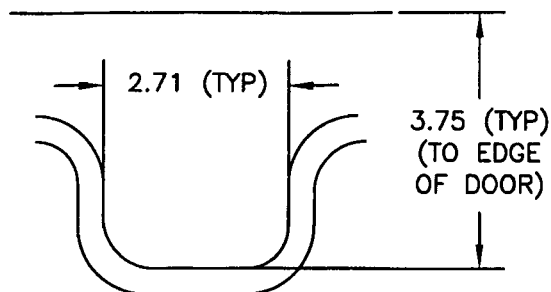
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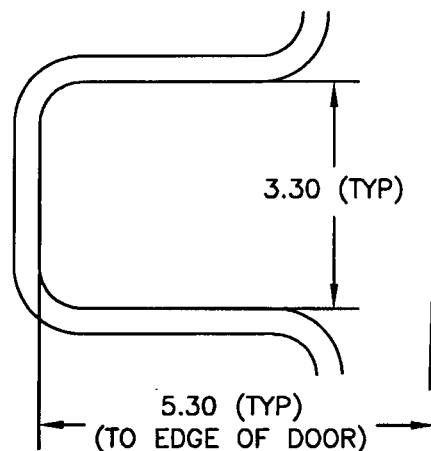
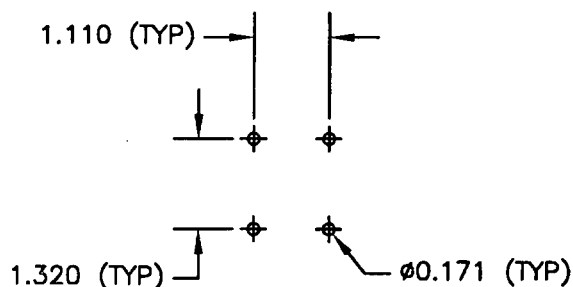
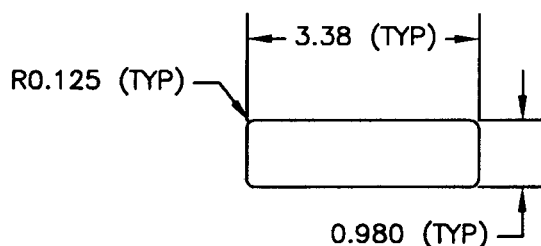
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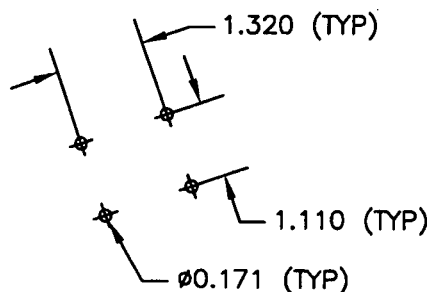
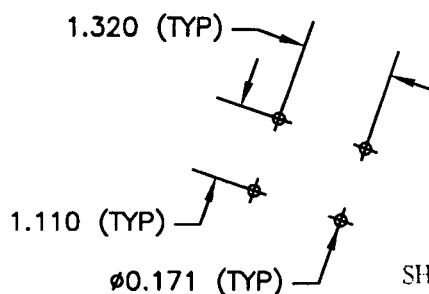
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.22

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F****NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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